



Aromatic Carbothane™ AC Series TPU

20% Barium Sulfate Filled Thermoplastic Polyurethane

Type: Radiopaque (20% BaSO₄ filled) medical grade polycarbonate-based aromatic Thermoplastic Polyurethanes (TPUs)

Features: This series exhibits excellent oxidative stability in blood contact and provides superior mechanical performance and chemical resistance properties. The inclusion of 20% (by weight) barium sulfate (BaSO₄) in the material provides radiopaque properties.

Process: Extrusion and injection molding

Products & Properties	ASTM Test	AC-4075A-B20	AC-4085A-B20	AC-4095A-B20	AC-4055D-B20
Durometer (Shore Hardness)	D2240	78A	90A	95A	56D
Specific Gravity	D792	1.38	1.40	1.43	1.44
Ultimate Tensile (psi)	D412	8300	8900	9300	10,000
Ultimate Elongation (%)	D412	400	360	300	350
Tensile Modulus (psi)	D412				
at 100% Elongation		560	1700	3300	3600
at 200% Elongation		1300	3500	5700	5400
at 300% Elongation		3400	6600	n/a	8600
Flexural Modulus (psi)	D790	1800	5700	10,900	20,700
Vicat Temperature (°C)	D1525	55	82	94	95
Mold Shrinkage (in/in) (1"x.25"x6" bar)	D955	0.011	0.010	0.009	0.009

Note: These test results are based on small samples of Carbothane™ polyurethanes and do not necessarily represent average results from larger test samples. This information should not be used for establishing engineering or manufacturing guidelines or specifications.



LIFE SCIENCE 9911 Brecksville Road, Cleveland, OH 44141-3201 USA

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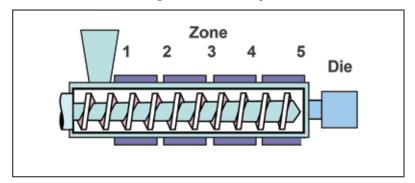




Handling Conditions: Properties of all thermoplastic polyurethane products in the molten state are adversely affected by moisture. For the best results, always dry the material at least two hours at 95°C (200°F) or overnight at 80°C (180°F) in a machine mounted dehumidifying dryer (a desiccant dryer delivering air at 1 liter/sec/kg at -40°C dew point (1 cfm/lb at -40°F dew point). A dehumidifying dryer hopper or one shot loader is also recommended. Depending on the applied processing technique, the **maximum moisture level should be 0.02%**. Never to exceed 500°F (260°C) melt temperature.

Processing Conditions: Carbothane™ Aromatic TPU's can be processed on any conventional extruder or molder. Please refer to Lubrizol's <u>processing guides</u> for medical TPUs for further recommendations regarding equipment and process design.

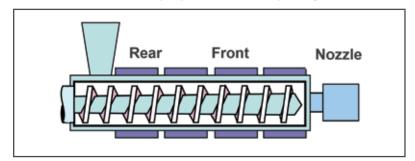
Recommended Starting Extrusion Temperature Profile:



	AC-4075A-B20	AC-4085A-B20	AC-4095A-B20	AC-4055D-B20
	°F/°C	°F/°C	°F/°C	°F/°C
Zone 1	390/199	390/199	390/199	410/210
Zone 2	400/204	400/204	400/204	420/215
Zone 3	410/210	410/210	410/210	430/221
Zone 4	410/210	410/210	410/210	430/221
Adapter 5	400/204	400/204	400/204	420/215
Die	400/204	400/204	400/204	420/215

Screen Pack Recommendation: 100/250/100 mesh

Recommended Starting Injection Molding Temperature Profile:



	AC-4075A-B20	AC-4085A-B20	AC-4095A-B20	AC-4055D-B20
	°F/°C	°F/°C	°F/°C	°F/°C
Rear	365/185	365/185	374/190	374/190
Front	365/185	365/185	392/200	392/200
Nozzle	356/180	356/180	356/180	356/180
Melt	365/185	365/185	374/190	374/190
Mold	50-80/10-27	50-80/10-27	50-80/10-27	50-100/10-38

Further guidance is available on the LLS Health Resource Hub or by contacting our technical solutions team.



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