

TECHNICAL DATA SHEET

LARIPUR 6650

GENERAL DESCRIPTION

LARIPUR 6650 is a modified polyester-based TPU able to combine low-temperature flexibility and impact resistance with high hardness. It is specifically designed for injection moulding of ski boots and technical items.

TYPICAL CHEMICAL- PHYSICAL PROPERTIES

Parameter		Typical Value	Unit	Method
Density		1.20	gr/cm ³	ISO 2781
Shore Hardness		62	D	ISO 7619-1
Abrasion Loss		30	mm ³	ISO 4649
Tensile Modulus:	50%	19.3	N/mm ²	ISO 22654
	100%	22.2		
	300%	42.1		
Tensile Strength		65.2	N/mm ²	ISO 22654
Elongation at Break		400	%	ISO 22654
Tear Strength		182	N/mm	ISO 34-1
Flexural Modulus		410	N/mm ²	ISO 178
Vicat Softening Point		152	°C	ISO 306
Impact Test	-20°C	6.8	kJ/m ²	ASTM D6110

The above reported data do not constitute sales specifications for the material in object.

The properties reported in this Technical Data Sheet are determined on annealed, injection moulded specimens and represent the average of values obtained from a significant number of production lots.

The international standards above indicated are intended as a reference for the execution of the relative tests, whereas the choice of available options and any possible variation are detailed in our respective internal standards.

The informations reported in this Technical Data Sheet are based on our current best knowledge, however, even if we guarantee the quality consistency of our LARIPUR products, we reserve the option to periodically issue updated versions of this Technical Data Sheet and respective sale specifications as well.

The extrusion grade LARIPUR are identified by a specific end code (EG, EA, AE, DP, EM, EF, EP, U,

EUV or HFM). This code has to be indicated when ordering those grades.

STORAGE AND STABILITY

LARIPUR 6650 is supplied in regular pelletized form and packaged in 25 kg bags or 500 kg and 1000 kg octabins.

LARIPUR 6650 must be stored in its original and sealed containers and kept in a dry and well-ventilated place, avoiding the direct sun radiation.

The shelf life of LARIPUR 6650 is of six months from shipment date, if stored in its original sealed packaging and in proper conditions.

SAFETY

The product is not considered dangerous, nevertheless we recommend to read the Material Safety Data Sheet before handling.

PROCESSING RECOMMENDATIONS

Before processing, material needs to be dried at 80-90°C for 3 hours, preferably using a dehumidifying drier fed by air with a dew point lower than -30°C.

Suggested moulding temperature profile:

Zone	Temperature
Zone 1	205°C
Zone 2	210°C
Zone 3	215°C
Nozzle	210°C

Being affected by the type of machine used, processing conditions and downstream equipment, the suggested temperature profile has to be considered as just indicative.

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