

## Technical Data Sheet

**Type:** ESTANE® SKN 85C0 is a polyester type Thermoplastic Polyurethane (TPU).

**Features:** It is a Plasticizer-free soft polyester TPU with excellent mechanical properties, fast cycle time, less-blooming, good transparency and UV stability.

**Uses:** General injection molding

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (5 sec)	85 +/- 3	Shore A	ASTM D-2240
Specific Gravity	1.22		ASTM D-792
Tensile Strength	30	psi (MPa)	ASTM D-412
Ultimate Elongation	750	%	"
Tensile Stress at:			
- 100 % Elongation	6.0	psi (MPa)	ASTM D-412
- 300 % Elongation	9.5	psi (MPa)	"
Tear Strength			
Graves	105	Lb/in (kg/mm)	ASTM D-624 (die C)
Abrasion	35	Cc loss	ISO 4649

**Remark :**

- Prior to testing samples were conditioned at 23°C for 48 hours.
- Based on injected part (2mm)
- Listed values are "typical (average) values" and should/cannot be applied for specification purposes.

## Supply Form and Standard Packaging

- ESTANE® SKN 85C0 is supplied in pellet form and packaged in 25kgs bag.

## Material Preparation

- Prior to processing, ESTANE® SKN 85C0 must be dried at 158~176°F (70~80°C) for 2-4 hours.
- It is recommended to dry the material in a desiccant type dryer. Target dew point should be -40°C.
- Depending on the applied processing technique, the maximum moisture level should be 0.02%.

## Material Preparation

- ESTANE® SKN 85C0 can be processed on any conventional Injection molding machine.

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**Recommended Starting Injection Molding Temperature Profile:**

	°C
<b>Zone 1</b>	<b>190</b>
<b>Zone 2</b>	<b>195</b>
<b>Zone 3</b>	<b>195</b>
<b>Zone 4</b>	<b>200</b>

**Injection pressure/speed: low/slow****For further information refer to Lubrizol Advanced Materials processing guides.**

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