

## Technical Data Sheet

**Type:** Estane<sup>®</sup> SKN 95C6 KR is a 95 shore A polyester-type thermoplastic polyurethane

**Features:** High transparency, UV resistance

**Uses:** Injection molding

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (5 sec)	95 +/-3	Shore A	ASTM D-2240
Specific Gravity	1.23	-	ASTM D-792
Tensile Strength	42	Mpa	ASTM D-412
Ultimate Elongation	630	%	ASTM D-412
Tensile Stress at:			
- 100 % Elongation	11	Mpa	ASTM D-412
- 300 % Elongation	19	Mpa	ASTM D-412
Tear Strength			
Graves	145	KN/m	ASTM D-624

**Remark:**

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

## Supply Form and Standard Packaging

- Estane<sup>®</sup> SKN 95C6 KR is supplied in pellet form and packaged in 25kgs bags.

## Material Preparation

- Prior to processing, Estane<sup>®</sup> SKN 95C6 KR must be dried at **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<sup>®</sup> SKN 95C6 KR can be processed on any conventional injection molding machine.

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**Recommended Starting INJECTION MOLDING Temperature Profile:**

	°F/°C
<b>Zone 1</b>	<b>392/200</b>
<b>Zone 2</b>	<b>401/205</b>
<b>Zone 3</b>	<b>410/210</b>
<b>Nozzle</b>	<b>419/215</b>

Fill rate: Moderate; Injection speed: Moderate

**For further information refer to Lubrizol Advanced Materials processing guides.**

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