

Technical Data Sheet

Type: Estane[®] S168D is a Shore 68D, polyester grade thermoplastic polyurethane (TPU). FDA approved (21 CFR 177.2600, 177.1680)

Uses: Injection Molding

Physical Properties	Standard No.	Units	Value
Hardness	ASTM D2240	Shore D	68
Specific Gravity	ASTM D792	g/cm ³	1.27
Mechanical			
Tensile Stress:	ASTM D412	kgf/cm ²	
At 100% elongation			280
At 300% elongation			400
Tensile Strength	ASTM D412	kgf/cm ²	450
Ultimate Elongation	ASTM D412	%	430
Tear Resistance (Die C)	ASTM D624	kgf/cm	250
Abrasion Loss	ISO 4649	mm ³ loss	25
Compression Set			
At 23°C X22hr		%	20
At 70°C X22hr		%	45
Mold Shrinkage	ASTM D955	m/m	0.006
Thermal			
Vicat Softening Temperature	ASTM D1525	°C	163

*Test samples were annealed at 100°C and 24 hours at room temperature before testing.

**These are typical values and should not be used for specifications.

Injection Molding Guide

These settings are to be used only as a guide. This is a typical injection molding temperature profile based on the Test Machine (conditions based on a 75 ton machine with a general purpose screw – L/D 17 – Ø 35mm). The optimal run conditions for specific equipment will vary depending on the machine and mold design.

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