

Technical Data Sheet

Type: : Estane® SKN 75C0 is a 77 shore A Polyester-Type Thermoplastic Polyurethane (TPU).

Features: UV stabilized plasticizer free soft TPU

Uses: Injection molding

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (5 sec)	77 +/- 3	Shore A	ASTM D-2240
Specific Gravity	1.14		ASTM D-792
Tensile Strength	4060 (28)	psi (MPa)	ASTM D-412
Ultimate Elongation	840	%	"
Tensile Stress at:			
- 100 % Elongation	522 (3.6)	psi (MPa)	ASTM D-412
- 300 % Elongation	870 (6)	psi (MPa)	"
Tear Strength			
Graves	420 (75)	lbf/in(kgf/cm)	ASTM D-624 (die C)

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

Supply Form and Standard Packaging

- Estane® SKN 75C0 is supplied in pellet form and packaged in 25kgs bag.

Material Preparation

- Prior to processing, Estane® SKN 75C0 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 0.05%.

Material Preparation

- Estane® SKN 75C0 can be processed on any conventional injection molding machine.

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Recommended Starting INSERT INJECTION MOLDING Temperature Profile:

	°F/°C
Zone 1	374/190
Zone 2	383/195
Zone 3	392/200
Nozzle	383/195

Fill rate : Slow**Mold shrinkage * : 0.08 (flex bar) cm/cm**

* *Mold shrinkage was determined using ASTM D955. Actual shrinkage will vary with part size, design and processing conditions.*

For further information refer to Lubrizol Advanced Materials processing guides.

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