

Type: Estane[®] S368D-7N is a 68 shore D Polyester-Type Thermoplastic Polyurethane (TPU).

Description: UV stabilized and good transparency

Uses: Injection molding

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (5 sec)	68 +/-3	Shore D	ASTM D-2240
Specific Gravity	1.23		ASTM D-792
Tensile Strength	6525 (45)	psi (MPa)	ASTM D-412
Ultimate Elongation	380	%	"
Tensile Stress at			
- 100 % Elongation	3480 (24)	psi (MPa)	ASTM D-412
- 300 % Elongation	4785 (33)	psi (MPa)	"
Tear Strength			
- Graves	1232 (220)	lbf/in(kgf/cm)	ASTM D-624 (die C)
Abrasion Loss	45	mg loss	ISO 4649

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[®] S368D-7N is supplied in pellet form and packaged in 25kg bags.

Material Preparation

- Prior to processing, Estane[®] S368D-7N must be dried at 176~194°F (80~90°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%.

Processing Conditions

- Estane[®] S368D-7N can be processed on any conventional injection molding machine.

See reverse side for processing information.

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Recommended Starting Injection molding Temperature Profile:

	°F/°C
Zone 1	383/195
Zone 2	410/210
Zone 3	410/210
Nozzle	419/215

Fill rate: Fast

For further information refer to Lubrizol Advanced Materials processing guides.

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