

Type: Estane® S395A-27N is a 95 shore A Polyester-Type Thermoplastic Polyurethane (TPU).

Description: UV stabilized and good transparency

Uses: Injection molding

Physical Properties	Value (Metric)	Unit	Test Method
Hardness (5 sec)	95 +/- 3 45 +/-3	Shore A Shore D	ASTM D-2240
Specific Gravity	1.22		ASTM D-792
Tensile Strength	6525 (45)	psi (MPa)	ASTM D-412
Ultimate Elongation	600	%	"
Tensile Stress at			
- 100 % Elongation	2030 (14)	psi (MPa)	ASTM D-412
- 300 % Elongation	3625 (25)	psi (MPa)	"
Tear Strength			
- Graves	728 (130)	lbf/in(kgf/cm)	ASTM D-624 (die C)
Abrasion Loss	40	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® S395A-27N is supplied in pellet form and packaged in 25kg bags.

Material Preparation

- Prior to processing, Estane® S395A-27N 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%.

Processing Conditions

- Estane® S395A-27N 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	374/190
Zone 2	383/195
Zone 3	383/195
Nozzle	392/200

Fill rate: Moderate

For further information refer to Lubrizol Advanced Materials processing guides.

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