

**Type:** Estane<sup>®</sup> S398A-7N is a 98 shore A/52 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)	98 +/- 2 52 +/-3	Shore A Shore D	ASTM D-2240
Specific Gravity	1.22		ASTM D-792
Tensile Strength	6235 (43)	psi (MPa)	ASTM D-412
Ultimate Elongation	420	%	"
Tensile Stress at			
- 100 % Elongation	2610 (18)	psi (MPa)	ASTM D-412
- 300 % Elongation	4350 (30)	psi (MPa)	"
Tear Strength			
- Graves	896 (160)	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<sup>®</sup> S398A-7N is supplied in pellet form and packaged in 25kg bags.

### Material Preparation

- Prior to processing, Estane<sup>®</sup> S398A-7N 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<sup>®</sup> S398A-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
<b>Zone 1</b>	383/195
<b>Zone 2</b>	392/200
<b>Zone 3</b>	392/200
<b>Nozzle</b>	401/205

**Fill rate : Moderate**

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

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