



THERMOPLASTICPOLYURETHANES

Technical Date Sheet

Noveon[®] 1155D TPEE

Type: Noveon[®] 1155D is a 55D TPEE Material for general purpose, low modulus, injection and extrusion grade.

Feature: excellent bending resistance and fatigue resistance; excellent impact resistance performance in -40°C; very good tear resistance and wear resistance etc.

Application: Auto interior, soft touch Grips, over-molding parts, etc.

Physical Properties	Value (Metric)	Unit	Test Method
Hardness	55	Shore D	ASTM D-2240
Melt Mas-Flow Rate MFR	25	g/10min	ASTM D1238
Specific Gravity	1.20	g/cm ³	ASTM D-792
Water Absorption	0.6	%	ASTM D570
Tensile Strength	450	Kg/cm ²	ASTM D-638
Tensile Elongation	800	%	ASTM D-638
Flexural Modulus	2000	Kg/cm ²	ASTM D-790
Notched Izod Impact	NB	Kg.cm/cm	ASTM D-256
Heat Deflection Temp	90	°C	ASTM D-648
Volume Resistivity	>E13	Ohms.cm	ASTM D257
Dielectric strength	26	KV/mm	ASTM D149
Comparative Tracking index	600	V	IEC 60112
Flame Rating	HB		UL94



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Processing

Injection

Drying Temperature	80 to 90 °C
Drying Time	3.0 to 4.0 hrs
Melt temp	200 to 240 °C
Rear Temp	200-220°C
Middle Temp	210-230°C
Front Temp	230-240°C
Nozzle Temp	220 to 240°C
Mold Temp	20 to 40°C



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Extrusion

Drying Temp	80-90°C
Drying Time	3.0-40 hrs
Melt Temp	200-240°C
Zone 1	200-220°C
Zone 2	230-230°C
Zone 3	210-230°C
Zone 4	210-230°C
Adapter Temp	210-230°C
Die Temp	200-220°C