



THERMOPLASTICPOLYURETHANES

Technical Date Sheet

Noveon[®] 1163D TPEE

Type: Noveon[®] 1163D is a 61D 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, cable & wire, tube etc.

Physical Properties	Value (Metric)	Unit	Test Method
Hardness	61	Shore D	ASTM D-2240
Melt Mas-Flow Rate MFR	24	g/10min	ASTM D1238
Specific Gravity	1.23	g/cm ³	ASTM D-792
Water Absorption	0.3	%	ASTM D570
Tensile Strength	500	Kg/cm ²	ASTM D-638
Tensile Elongation	650	%	ASTM D-638
Flexural Modulus	3300	Kg/cm ²	ASTM D-790
Notched Izod Impact	NB	Kg.cm/cm	ASTM D-256
Heat Deflection Temp	111	°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	210 to 240 °C
Rear Temp	210-230°C
Middle Temp	220-240°C
Front Temp	225-245°C
Nozzle Temp	225 to 245°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	210-240°C
Zone 1	210-230°C
Zone 2	220-240°C
Zone 3	220-240°C
Zone 4	220-240°C
Adapter Temp	220-240°C
Die Temp	210-230°C