



THERMOPLASTICPOLYURETHANES

Technical Data Sheet

Noveon[®] 1135D TPEE

Type: Noveon[®] 1135D is a 33D 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	33	Shore D	ASTM D-2240
Melt Mas-Flow Rate MFR	25	g/10min	ASTM D1238
Specific Gravity	1.11	g/cm ³	ASTM D-792
Water Absorption	0.7	%	ASTM D570
Tensile Strength	200	Kg/cm ²	ASTM D-638
Tensile Elongation	750	%	ASTM D-638
Flexural Modulus	N/A	Kg/cm ²	ASTM D-790
Notched Izod Impact	NB	Kg.cm/cm	ASTM D-256
Heat Deflection Temp	N/A	°C	ASTM D-648
Volume Resistivity	/	Ohms.cm	ASTM D257
Dielectric strength	/	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	165 to 205 °C
Rear Temp	170-190°C
Middle Temp	180-200°C
Front Temp	190-210°C
Nozzle Temp	190 to 210°C
Mold Temp	10 to 35°C



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Extrusion

Drying Temp	80-90°C
Drying Time	3.0-4.0 hrs
Melt Temp	165-205°C
Zone 1	170-190°C
Zone 2	180-200°C
Zone 3	180-200°C
Zone 4	180-200°C
Adapter Temp	180-200°C
Die Temp	180-200°C