

**TECHNICAL DATA SHEET**

# SKYPEL G163D

SK Chemicals

TPE

**Processing**

Injection molding, Other extrusion

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	14	g/10min	ASTM D 1238
Temperature	230	°C	
Load	2.16	kg	
Mold shrinkage, MD	0.015	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile strength at break	43.2	MPa	ASTM D 638
Elongation at break	500	%	ASTM D 638
Flexural modulus	314	MPa	ASTM D 790
Shore D hardness	63		ASTM D 2240
Tear strength	180	kN/m	ASTM D 624
Izod impact notched, 1/4 in	N	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
DTUL @ 66 psi	130	°C	ASTM D 648
Melting temperature	212	°C	ASTM D 3418
Other Properties	Value	Unit	Standard
Water absorption, 24hr	0.3	%	ASTM D 570
Density	1210	kg/m <sup>3</sup>	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	100	°C	
Pre-drying - time	2 - 3	h	
Mold temperature	40	°C	
Zone 1	220	°C	
Zone 2	230	°C	

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Processing Recommendation Injection Molding	Value	Unit	Standard
Zone 3	230	°C	
Nozzle temperature	235	°C	

  

Processing Recommendation Extrusion	Value	Unit	Standard
Pre-drying - temperature	100	°C	
Pre-drying - time	2 - 3	h	
Melt temperature	230	°C	
Zone 1	210	°C	
Zone 2	220	°C	
Zone 3	225	°C	
Nozzle temperature	225	°C	