SKYPEL® G155D

SK Chemicals - Thermoplastic Polyester Elastomer

General Information

General		
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/2.16 kg)	11	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2]			ASTM D638
5.0% Strain, 0.0787 in, Injection Molded	925	psi	
10% Strain, 0.0787 in, Injection Molded	1640	psi	
Tensile Strength [2] (Break, 0.0787 in, Injection Molded)	5690	psi	ASTM D638
Tensile Elongation [2]			ASTM D638
Break, 0.0787 in, Injection Molded	600	%	
Flexural Modulus [3]	29900	psi	ASTM D790
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tear Strength [4] (0.0787 in)	942	lbf/in	ASTM D1004
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore D)	55		ASTM D2240
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	221	°F	ASTM D648
Peak Crystallization Temperature (DSC) [5]	396	°F	ASTM D3418

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	401	°F
Middle Temperature	419	°F
Front Temperature	428	°F
Nozzle Temperature	437	°F
Mold Temperature	95	°F
Extrusion	**Nominal Value**	**Unit**
Cylinder Zone 1 Temp.	383	°F
Cylinder Zone 3 Temp.	410	°F
Cylinder Zone 5 Temp.	410	°F
Melt Temperature	419	°F
Die Temperature	410	°F