



**Product Data Sheet &
General Processing Conditions**

**RTP 1200 S-65D TFE 10
Ester-based Thermoplastic Polyurethane
Elastomer (TPUR/TPU)
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|----------------------------|------------------|------------------|
| Primary Additive | 10 % | 10 % | |
| Specific Gravity | 1.27 | 1.27 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0110 in/in | 1.10 % | D 955 |
| MECHANICAL | | | |
| Tensile Strength | 6500 psi | 45 MPa | D 638 |
| Tensile Elongation | > 400.0 % | > 400.0 % | D 638 |
| Flexural Modulus | 0.04 x 10 ⁶ psi | 276 MPa | D 790 |
| Hardness Shore D, instantaneous | 65 | 65 | D 2240 |

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

| | English | SI Metric |
|--------------------|-------------------|------------------|
| Injection Pressure | 10000 - 15000 psi | 69 - 103 MPa |
| Melt Temperature | 320 - 425 °F | 160 - 218 °C |
| Mold Temperature | 100 - 140 °F | 38 - 60 °C |
| Drying | 6 hrs @ 225 °F | 6 hrs @ 107 °C |
| Moisture Content | 0.01 % | 0.01 % |
| Dew Point | 0 °F | -18 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.