



**Product Data Sheet &
General Processing Conditions**

**RTP 1205 S-65D
Ester-based Thermoplastic Polyurethane
Elastomer (TPUR/TPU)
Glass Fiber**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.45	1.45	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0005 - 0.0020 in/in	0.05 - 0.20 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	7.5 ft-lbs/in	400 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength Type I, 0.125 in, 0.2 in/min (3.2mm, 5 mm/min)	11000 psi	76 MPa	D 638
Tensile Elongation Break, Type I, 0.125 in, 0.2 in/min (3.2mm, 5 mm/min)	20.0 %	20.0 %	D 638
Tensile Modulus Type I, 0.125 in, 0.2 in/min (3.2mm, 5 mm/min)	0.40 x 10 ⁶ psi	2758 MPa	D 638
Flexural Strength 5% Strain, 0.125 in, 0.05 in/min (3.2mm, 1.2 mm/min)	10000 psi	69 MPa	D 790
Flexural Modulus	0.30 x 10 ⁶ psi	2068 MPa	D 790
Hardness Shore D, instantaneous	75	75	D 2240

THERMAL

Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
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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.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	5000 - 15000 psi	34 - 103 MPa
Melt Temperature	400 - 430 °F	204 - 221 °C
Mold Temperature	80 - 140 °F	27 - 60 °C
Drying	4 - 6 hrs @ 210 - 230 °F	4 - 6 hrs @ 99 - 110 °C
Moisture Content	< 0.02 %	< 0.02 %
Dew Point	< -20 °F	< -29 °C

PROCESSING NOTES

Desiccant Type Dryer Required.