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**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**

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

|                    | <b>English</b>    | <b>SI Metric</b> |
|--------------------|-------------------|------------------|
| 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.