

Texin® 1210

Thermoplastic Polyurethane Elastomer (Polyester)

Covestro - PUR

Message:

Texin 1210 resin is an aromatic polyester-based thermoplastic polyurethane with a Shore hardness of approximately 92A.

General Information			
Features	Low speed solidification crystal point Solvent resistance Good wear resistance Good chemical resistance Oil resistance Compliance of Food Exposure Medium transparency		
Uses	Films Cable sheath Pipe Pipe fittings Sheet Footwear Profile		
Agency Ratings	FDA 21 CFR 177.1680 FDA 21 CFR 177.2600		
Appearance	Natural color		
Processing Method	Extrusion Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792, ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	92		ASTM D2240, ISO 868
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus			ASTM D790, ISO 178
23°C	73.1	MPa	ASTM D790, ISO 178
70°C	31.7	MPa	ASTM D790, ISO 178
Taber Abrasion Resistance			
1000 Cycles, 1000g, H-18 wheel	27.0	mg	ISO 4649

1000 Cycles, 1000g, H-18 wheel	27.0	mg	ASTM D1044
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412, ISO 37
100% strain	9.70	MPa	ASTM D412, ISO 37
300% strain	20.0	MPa	ASTM D412, ISO 37
Tensile Strength (Yield)	40.0	MPa	ASTM D412, ISO 37
Tensile Elongation (Break)	510	%	ASTM D412, ISO 37
Tear Strength			
-- ¹	129	kN/m	ASTM D624
--	130	kN/m	ISO 34-1
Compression Set ²			ASTM D395B, ISO 815
23°C, 22 hr	16	%	ASTM D395B, ISO 815
70°C, 22 hr	43	%	ASTM D395B, ISO 815
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	-14.0	°C	DMA
Vicat Softening Temperature	88.0	°C	ISO 306/50, ASTM D1525 ³
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	81.0 - 104	°C	
Drying Time - Desiccant Dryer	2.0	hr	
Suggested Max Moisture	< 0.030	%	
Suggested Max Re grind	20	%	
Rear Temperature	182 - 196	°C	
Middle Temperature	188 - 204	°C	
Front Temperature	193 - 207	°C	
Nozzle Temperature	196 - 210	°C	
Processing (Melt) Temp	191 - 204	°C	
Mold Temperature	16.0 - 38.0	°C	
Injection Pressure	41.4 - 103	MPa	
Injection Rate	Moderate		
Back Pressure	< 5.52	MPa	
Screw Speed	40 - 80	rpm	
Cushion	< 3.18	mm	
Injection instructions			
Hold Pressure: 60 to 80% of Injection Pressure			
Extrusion	Nominal Value	Unit	
Drying Temperature	81.0 - 104	°C	
Drying Time	2.0	hr	
Cylinder Zone 1 Temp.	182 - 199	°C	
Cylinder Zone 2 Temp.	182 - 204	°C	
Cylinder Zone 3 Temp.	182 - 204	°C	
Melt Temperature	191 - 204	°C	
Die Temperature	188 - 204	°C	

NOTE

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|----|---------------------------|
| 1. | C mould |
| 2. | Post-cured 16 hr at 230°F |
| 3. | 速率 A (50°C/h) |

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