



# Texin<sup>®</sup> 270D

## Characterization

Texin 270D resin is an aromatic polyester-based thermoplastic polyurethane with a Shore hardness of approximately 70D\*. It can be processed by injection molding; extrusion processes are not recommended.

## Properties / Applications

Texin 270D resin exhibits excellent fuel and oil resistance. It also provides high stiffness, tensile and tear properties. Texin 270 natural color resin complies with FDA food-contact regulations 21 CFR 177.1680 (Polyurethane Resins) and 177.2600 (Rubber Articles Intended for Repeated Use), subject to the limitations of these and any other applicable regulations. Typical applications include caster wheels, gears, sprockets, and sporting equipment. As with any product, use of Texin 270D resin in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

## Storage

Texin thermoplastic polyurethane resins are hygroscopic and will absorb ambient moisture. The presence of moisture can adversely affect processing characteristics and the quality of parts. Therefore, the resins should remain in their sealed containers and be stored under cool and dry conditions until used. Storage temperature should not exceed 86°F (30°C). Unused resin from opened containers, or reground material that is not to be used immediately, should be stored in sealed containers.

## Drying

Prior to processing, Texin 270D resin must be thoroughly dried in a desiccant dehumidifying hopper dryer. Hopper inlet air temperature should be 210°–230°F (100°–110°C). To achieve the recommended moisture content of less than 0.03%, the inlet air dew point should be -20°F (-29°C) or lower. The hopper capacity should be sufficient to provide a minimum residence time of 4 hours. Additional information on drying procedures is available in the brochure - General Drying Guide.



# Texin<sup>®</sup> 270D

## Injection Molding

General-purpose screws are satisfactory for use with Texin 270D resin. The recommended screw length-to-diameter (L/D) ratio is 20:1 with a compression ratio of 2.5 –3:1. Screws with a compression ratio greater than 4:1 should be avoided. Recommended shot weight is 40-80 % of rated barrel capacity. Typical starting conditions are noted below. Actual processing conditions will depend on machine size, mold design, material residence time, etc.

## Typical Injection Molding Conditions

|                                     |                                |
|-------------------------------------|--------------------------------|
| Barrel Temperature: Rear            | 410°–435°F (210°–2245°C)       |
| Barrel Temperature: Middle          | 415°–440°F (210°–227°C)        |
| Barrel Temperature: Front           | 415°–440°F (210°–227°C)        |
| Barrel Temperature: Nozzle          | 420°–445°F (216°–229°C)        |
| Melt Temperature                    | 420°–445°F (216°–229°C)        |
| Mold Temperature                    | 85°–120°F (29°–49°C)           |
| Injection Pressure                  | 10,000 - 18,000 psi            |
| Hold Pressure                       | 60 - 80% of Injection Pressure |
| Back Pressure                       | 800 psi max.                   |
| Screw Speed                         | 40 - 80 rpm                    |
| Injection Speed                     | Slow to Moderate               |
| Cushion                             | 1/8 in max                     |
| Clamp                               | 3 - 5 ton/in <sup>2</sup>      |
| Timers (per 0.125-in cross section) |                                |
| Boost                               | 5 -10 sec                      |
| 2nd Stage                           | 10- 20 sec                     |
| Cool                                | 20 - 30 sec                    |

## Mold Shrinkage

Typical values for mold shrinkage are given below. For treatments such as postcuring, an additional 1 to 1.5 mil per inch should be added.

| Cross Section      | Mold Shrinkage*       |
|--------------------|-----------------------|
| Less than 1/8 inch | 7 - 10 mils per inch  |
| 1/8 to 1/4 inch    | 10 - 15 mils per inch |
| Over 1/4 inch      | 15 - 20 mils per inch |

## Additional Injection Molding Information

Additional information on injection molding may be obtained by consulting the publication Texin and Desmopan Thermoplastic Polyurethanes — A Processing Guide for Injection Molding and by contacting a Covestro technical service representative.



# Texin<sup>®</sup> 270D

## Regrind Usage

Where end-use requirements permit, up to 20% Texin resin regrind may be used with virgin material, provided that the material is kept free of contamination and is properly dried (see section on Drying). Any regrind used must be generated from properly molded/extruded parts, sprues, runners, trimmings, and/or films. All regrind used must be clean, uncontaminated, and thoroughly blended with virgin resin prior to drying and processing. Under no circumstances should degraded, discolored, or contaminated material be used for regrind. Materials of this type should be properly discarded.

Improperly mixed and/or dried regrind may diminish the desired properties of Texin resin. It is critical that you test finished parts produced with any amount of regrind to ensure that your end-use performance requirements are fully met. Regulatory or testing organizations (e.g., Underwriter's Laboratories) may have specific requirements limiting the allowable amount of regrind. Because third party regrind generally does not have a traceable heat history or offer any assurance that proper temperatures, conditions, and/or materials were used in processing, extreme caution must be exercised in buying and using regrind from third parties.

The use of regrind material should be avoided entirely in those applications where resin properties equivalent to virgin material are required, including but not limited to color quality, impact strength, resin purity, and/or load-bearing performance.



# Texin<sup>®</sup> 270D

## Typical Properties\* for Natural Resin

| Property   | ASTM Test Method<br>(Other) | Texin 270D Resin<br>U.S. Units | Texin 270D Resin<br>S.I. Units |
|--|-----------------------------|--------------------------------|--------------------------------|
| <b>General</b>   |                             |                                |                                |
| Specific Gravity                                       | D 792 (ISO 1183)            | 1.24                           | 1.24                           |
| Shore Hardness   | D 2240 (ISO 868)            | 70D                            | 70D                            |
| Taber Abrasion:<br>H-18, 1,000-g Load, 1,000<br>Cycles | D 3489 (ISO 4649)           | 90 mg Loss                     | 90 mg Loss                     |
| Bayshore Resilience                                    | D 2632                      | 55%                            | 55%                            |
| Mold Shrinkage,<br>100-mil thickness                   | D 955 (ISO 2577)            |                                |                                |
| Flow Direction   |                             | 0.008 in/in (mm/mm)            | 0.008 in/in (mm/mm)            |
| Cross-Flow Direction                                   |                             | 0.008 in/in (mm/mm)            | 0.008 in/in (mm/mm)            |
| <b>Mechanical</b>                                      |                             |                                |                                |
| Tensile Strength                                       | D 412 (ISO 37)              | 8,200 lb/in <sup>2</sup>       | 56.6 MPa                       |
| Tensile Stress at 50%<br>Elongation                    | D 412 (ISO 37)              | 4,100 lb/in <sup>2</sup>       | 28.3 MPa                       |
| Tensile Stress at 100%<br>Elongation                   | D 412 (ISO 37)              | 4,200 lb/in <sup>2</sup>       | 29.0 MPa                       |
| Tensile Stress at 300%<br>Elongation                   | D 412 (ISO 37)              | 6,200 lb/in <sup>2</sup>       | 42.8 MPa                       |
| Ultimate Elongation                                    | D 412 (ISO 37)              | 400%                           | 400%                           |
| Flexural Modulus:<br>158°F (70°C)                      | D 790 (ISO 178)             | 15,000 lb/in <sup>2</sup>      | 103 MPa                        |
| 73°F (23°C)  |                             | 105,000 lb/in <sup>2</sup>     | 724 MPa                        |
| -22°F (-30°C)  |                             | 422,000 lb/in <sup>2</sup>     | 2,910 MPa                      |
| Tear Strength, Die C                                   | D 624 (ISO 34)              | 1,300 lbf/in                   | 228 kN/m                       |
| Compression Set:<br>As molded [postcured] <sup>a</sup> | D 395-B (ISO 815)           |                                |                                |
| 22 Hours at 158°F (70°C)                               |                             | 85 [45]                        | 85 [45]                        |
| 22 Hours at 73°F (23°C)                                |                             | 50 [30]                        | 50 [30]                        |



# Texin<sup>®</sup> 270D

## Typical Properties\* for Natural Resin (CONT'D.)

| Property  | ASTM Test Method<br>(Other) | Texin 270D Resin<br>U.S. Units | Texin 270D Resin<br>S.I. Units |
|---|-----------------------------|--------------------------------|--------------------------------|
| <b>Mechanical</b>                                 |                             |                                |                                |
| Compressive Load:                                 | D 575                       |                                |                                |
| 2% Deflection                                     |                             | 550 lb/in <sup>2</sup>         | 3.8 MPa                        |
| 5% Deflection                                     |                             | 1,900 lb/in <sup>2</sup>       | 13.1 MPa                       |
| 10% Deflection                                    |                             | 3,150 lb/in <sup>2</sup>       | 21.7 MPa                       |
| 15% Deflection                                    |                             | 3,750 lb/in <sup>2</sup>       | 25.9 MPa                       |
| 20% Deflection                                    |                             | 4,250 lb/in <sup>2</sup>       | 29.3 MPa                       |
| 25% Deflection                                    |                             | 4,900 lb/in <sup>2</sup>       | 33.8 MPa                       |
| 50% Deflection                                    |                             | 9,550 lb/in <sup>2</sup>       | 65.8 MPa                       |
| <b>Thermal</b>                                    |                             |                                |                                |
| Deflection Temperature<br>Under Load              | D648 (ISO 75)               |                                |                                |
| 264 psi (1.82 MPa)                                |                             | 100°F                          | 38°C                           |
| 66 psi (0.46 MPa)                                 |                             | 115°F                          | 46°C                           |
| Coefficient of Linear Thermal<br>Expansion        | D 696                       | 5.5 E-05 in/in°F               | 9.9 E-05 mm/mm°C               |
| Low Temperature Brittle<br>Point                  | D 746 (ISO 974)             | < -90°F                        | < -68°C                        |
| Glass Transition<br>Temperature (T <sub>g</sub> ) | (DMA) <sup>b</sup>          | 32°F                           | 0°C                            |
| Vicat Softening Temperature<br>Rate A             | D 1525 (ISO 306)            | 316°F                          | 158°C                          |

\*These items are provided as general information only. They are approximate values and are not part of the product specifications.

<sup>a</sup> Postcured for 16 hours at 230°F (110°C).

<sup>b</sup> DMA — Dynamic Mechanical Analysis.



# Texin<sup>®</sup> 270D

## Property Changes after Aging Texin 270D Resin

| Property                            | ASTM Test Method (Other) | 70 Hours | 7 Days | 14 Days | 21 Days |
|-------------------------------------|--------------------------|----------|--------|---------|---------|
| <b>Hot Air at 212°F (100°C)</b>     | D 573 (ISO 216)          |          |        |         |         |
| Tensile Strength                    |                          | +17%     | +10%   | +9%     | +21%    |
| Tensile Stress at 100% Elongation   |                          | +10%     | +2%    | +2%     | +1%     |
| Tensile Stress at 300% Elongation   |                          | +12%     | +6%    | +4%     | +2%     |
| Ultimate Elongation                 |                          | +3%      | +3%    | +3%     | +15%    |
| Hardness, Shore D                   |                          | +1       | -6     | -5      | -1      |
| <b>ASTM Oil #1 at 212°F (100°C)</b> | D 471 (ISO 175)          |          |        |         |         |
| Tensile Strength                    |                          | +20%     | +7%    | +2%     | +8%     |
| Tensile Stress at 100% Elongation   |                          | +2%      | -1%    | -3%     | -6%     |
| Tensile Stress at 300% Elongation   |                          | +8%      | +7%    | -3%     | -11%    |
| Ultimate Elongation                 |                          | +8%      | -4%    | +4%     | +17%    |
| Hardness, Shore D                   |                          | -1       | -3     | -4      | -2      |
| Volume                              |                          | 0%       | 0%     | 0%      | 0%      |
| <b>ASTM Oil #3 at 212°F (100°C)</b> | D 471 (ISO 175)          |          |        |         |         |
| Tensile Strength                    |                          | +13%     | +29%   | +32%    | +20%    |
| Tensile Stress at 100% Elongation   |                          | 0%       | -1%    | -2%     | -8%     |
| Tensile Stress at 300% Elongation   |                          | +8%      | +4%    | -2%     | -11%    |
| Ultimate Elongation                 |                          | +4%      | +19%   | +36%    | +51%    |
| Hardness, Shore D                   |                          | -4       | -5     | -2      | -5      |
| Volume                              |                          | 0%       | +1%    | +2%     | +2%     |



# Texin<sup>®</sup> 270D

## Property Changes after Aging Texin 270D Resin (CONT'D.)

| Property                          | ASTM Test Method (Other) | 70 Hours | 7 Days | 14 Days | 21 Days |
|-----------------------------------|--------------------------|----------|--------|---------|---------|
| <b>Fuel A at 73°F (23°C)</b>      | D 471 (ISO 175)          |          |        |         |         |
| Tensile Strength                  |                          | -4%      | -5%    | 0%      | -2%     |
| Tensile Stress at 100% Elongation |                          | -4%      | -3%    | -3%     | -1%     |
| Tensile Stress at 300% Elongation |                          | -2%      | -4%    | +4%     | -1%     |
| Ultimate Elongation               |                          | 0%       | 0%     | -7%     | -1%     |
| Hardness, Shore D                 |                          | -1       | -5     | -1      | +2      |
| Volume                            |                          | 0%       | 0%     | 0%      | 0%      |
| <b>Fuel C at 73°F (23°C)</b>      | D 471 (ISO 175)          |          |        |         |         |
| Tensile Strength                  |                          | +10%     | -3%    | +8%     | +9%     |
| Tensile Stress at 100% Elongation |                          | -4%      | -6%    | -18%    | -21%    |
| Tensile Stress at 300% Elongation |                          | -1%      | +10%   | -4%     | -2%     |
| Ultimate Elongation               |                          | +15%     | -17%   | +12%    | +10%    |
| Hardness, Shore D                 |                          | 0        | -1     | -4      | -5      |
| Volume                            |                          | +1%      | +2%    | +2%     | +2%     |

\* This table shows property changes for Texin 270D resin after exposure to hot air, oil, and fuel. As is the case with any compatibility test, the results are dependent on variables, such as concentration, time, temperature, part design, and residual stresses, and should serve only as a guideline. It is imperative that production parts be evaluated under actual application conditions prior to commercial use.



# Texin<sup>®</sup> 270D

## Health and Safety Information

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling this product. Before working with this product, you must read and become familiar with the available information on its risks, proper use, and handling. This cannot be overemphasized. Information is available in several forms, e.g., safety data sheets and product labels. For further information contact your Covestro LLC representative or the Product Safety and Regulatory Affairs Department in Pittsburgh, PA.

---

## Note

***The purchaser/user agrees that Covestro LLC reserves the right to discontinue this product without prior notice.***

---

---

The manner in which you use and the purpose to which you put and utilize our products, technical assistance and information (whether verbal, written or by way of production evaluations), including any suggested formulations and recommendations, are beyond our control. Therefore, it is imperative that you test our products, technical assistance and information to determine to your own satisfaction whether our products, technical assistance and information are suitable for your intended uses and applications. This application-specific analysis must at least include testing to determine suitability from a technical as well as health, safety, and environmental standpoint. Such testing has not necessarily been done by us. Unless we otherwise agree in writing, all products are sold strictly pursuant to the terms of our standard conditions of sale which are available upon request. All information and technical assistance is given without warranty or guarantee and is subject to change without notice. It is expressly understood and agreed that you assume and hereby expressly release us from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance, and information. Any statement or recommendation not contained herein is unauthorized and shall not bind us. Nothing herein shall be construed as a recommendation to use any product in conflict with any claim of any patent relative to any material or its use. No license is implied or in fact granted under the claims of any patent.

---

Editor: Covestro LLC  
1 Covestro Circle  
Pittsburgh, Pennsylvania 15205  
United States  
[www.covestro.com](http://www.covestro.com)

**Contact:**  
TPU Single Point of Contact  
e-mail: [tpuinfo@covestro.com](mailto:tpuinfo@covestro.com)

page 8 of 8

Document contains important information and must be read in its entirety.

Edition 2019-04-01



Product Datasheet