

# Texin<sup>®</sup> 285A

## Characterization

Texin 285A resin is an aromatic polyester-based thermoplastic polyurethane with a Shore hardness of approximately 85A\*. It can be processed by injection molding, extrusion, and blow molding.

## Properties / Applications

In addition to good clarity, Texin 285A resin offers outstanding abrasion resistance, impact strength, toughness, and flexibility. Texin 285A 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 belting, tubing, hose, cable jackets, hose jackets, seals, athletic soles, casters, mine screens, film, and extruded profiles. Texin 285A resin can also be used as a polymer modifier. As with any product, use of Texin 285A 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 285A resin must be thoroughly dried in a desiccant dehumidifying hopper dryer. Hopper inlet air temperature should be 185°–200°F (85°–93°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> 285A

## Injection Molding

General-purpose screws are satisfactory for use with Texin 285A 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. To obtain good clarity in parts, Texin 285A resin must be molded on tools with a highly polished chrome surface. 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	360°–390°F (180°–200°C)
Barrel Temperature: Middle	360°–400°F (180°–205°C)
Barrel Temperature: Front	360°–410°F (180°–210°C)
Barrel Temperature: Nozzle	370°–415°F (185°–210°C)
Melt Temperature	385°–405°F (195°–205°C)
Mold Temperature	60°–110°F (15°–40°C)
Injection Pressure	6,000 - 15,000 psi
Hold Pressure	60 - 80% of Injection Pressure
Back Pressure	800 psi
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- 30 sec
Cool	30 - 50 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> 285A

## Extrusion

Texin 285A resin possesses a satisfactory melt strength and can be controlled over a wide range of temperature conditions to produce tubing, sheet, and extruded profiles. Typical starting conditions are noted below. Actual processing conditions vary and are dependent on size of extruders, extrusion rate, part geometry, etc.

### Typical Temperature Profile for Extrusion

Rear (Feed)	360°–390°F (180°–200°C)
Middle (Transition)	360°–400°F (180°–205°C)
Front (Meter)	360°–410°F (180°–210°C)
Adapter	360°–410°F (180°–210°C)
Die	370°–410°F (185°–210°C)
Melt	375°–400°F (190°–205°C)

### Additional Extrusion Information

The preferred screw design should have a compression ratio of 3:1 and should feature a long, gradual transition zone and a long meter zone. The recommended length- to-diameter (L/D) ratio is at least 24:1. Typical recommendations for 3:1 compression ratio screws on various sizes of 24:1 L/D extruders are given in the table below. Additional information on extrusion may be obtained by consulting the publication - Texin and Desmopan Thermoplastic Polyurethanes — A Processing Guide for Extrusion and by contacting a Covestro technical service representative.

Section	Number of Diameters	Depth ("h") in inches		
		2 1/2-in Extruder	3 1/2-in Extruder	4 1/2-in Extruder
Feed	5	0.375	0.450	0.525
Transition	7 - 13			
Meter	6 - 12	0.125	0.150	0.175

# Texin<sup>®</sup> 285A

## 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.

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## Regulatory Compliance Information

Some of the end uses of the products described in this bulletin must comply with applicable regulations, such as FDA, NSF, USDA, and CPSC. If you have any questions on the regulatory status of these products, contact your Covestro representative or Regulatory Affairs Manager in Pittsburgh, PA.

# Texin<sup>®</sup> 285A

## Typical Properties\* for Natural Resin

Property	ASTM Test Method (Other)	Texin 285A Resin U.S. Units	Texin 285A Resin S.I. Units
<b>General</b>			
Specific Gravity	D 792 (ISO 1183)	1.20	1.20
Shore Hardness	D 2240 (ISO 868)	85A	85A
Taber Abrasion: H-18, 1,000-g Load, 1,000 Cycles	D 3489 (ISO 4649)	35 mg Loss	35 mg Loss
Bayshore Resilience	D 2632	45%	45%
Mold Shrinkage, 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)	5,500 lb/in <sup>2</sup>	37.9 MPa
Tensile Stress at 50% Elongation	D 412 (ISO 37)	725 lb/in <sup>2</sup>	5.0 MPa
Tensile Stress at 100% Elongation	D 412 (ISO 37)	775 lb/in <sup>2</sup>	5.3 MPa
Tensile Stress at 300% Elongation	D 412 (ISO 37)	1,900 lb/in <sup>2</sup>	13.1 MPa
Ultimate Elongation	D 412 (ISO 37)	500%	500%
Flexural Modulus: 73°F (23°C)	D 790 (ISO 178)	4,000 lb/in <sup>2</sup>	27.6 MPa
-22°F (-30°C)		7,200 lb/in <sup>2</sup>	49.6 MPa
Tear Strength, Die C	D 624 (ISO 34)	500 lbf/in	87.6 kN/m

# Texin<sup>®</sup> 285A

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

Property	ASTM Test Method (Other)	Texin 285A Resin U.S. Units	Texin 285A Resin S.I. Units
<b>Mechanical</b>			
Compression Set:	D 395-B (ISO 815)		
As molded [postcured] <sup>a</sup>		65 [35]	65 [35]
22 Hours at 158°F (70°C)		16 [12]	16 [12]
22 Hours at 73°F (23°C)			
Compressive Load:	D 575		
2% Deflection		50 lb/in <sup>2</sup>	0.3 MPa
5% Deflection		150 lb/in <sup>2</sup>	1.0 MPa
10% Deflection		325 lb/in <sup>2</sup>	2.2 MPa
15% Deflection		475 lb/in <sup>2</sup>	3.3 MPa
20% Deflection		625 lb/in <sup>2</sup>	4.3 MPa
25% Deflection		825 lb/in <sup>2</sup>	5.7 MPa
50% Deflection		2,175 lb/in <sup>2</sup>	15.0 MPa
<b>Thermal</b>			
Low Temperature Brittle Point	D 746 (ISO 974)	< -90°F	< -68°C
Glass Transition Temperature (T <sub>g</sub> )	(DMA) <sup>b</sup>	-44°F	-42°C
Relative Temperature Index	(UL746B)		
0.059-in (1.5-mm) thickness		122°F	50°C
Electrical		122°F	50°C
Mechanical with impact		122°F	50°C
Mechanical without impact			
Vicat Softening Temperature Rate A	D 1525 (ISO 306)	196°F	91°C
<b>Flammability**</b>			
UL94 Flame Class	(UL94)		
0.059-in (1.5-mm) thickness		HB Rating <sup>c</sup>	HB Rating <sup>c</sup>
0.118-in (3.0-mm) thickness		V-2 Rating	V-2 Rating

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

\*\* Flammability results are based on small-scale laboratory tests for purposes of relative comparison and are not intended to reflect the hazards presented by this or any other material under actual fire conditions.

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

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

<sup>c</sup> Natural color.

# Texin<sup>®</sup> 285A

## Property Changes after Aging Texin 285A 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		+20%	+10%	+14%	+6%
Tensile Stress at 100% Elongation		-2%	-1%	-2%	-3%
Tensile Stress at 300% Elongation		+14%	+12%	+9%	+12%
Ultimate Elongation		+5%	+8%	+16%	+14%
Hardness, Shore D		-3	-3	-3	-3
<b>ASTM Oil #1 at 212°F (100°C)</b> D 471 (ISO 175)					
Tensile Strength		+20%	+9%	+7%	+1%
Tensile Stress at 100% Elongation		-5%	-1%	-2%	-4%
Tensile Stress at 300% Elongation		+10%	+10%	+10%	+10%
Ultimate Elongation		+18%	+18%	+29%	+29%
Hardness, Shore D		-3	-3	-3	-3
Volume		-1%	-1%	-1%	-1%
<b>ASTM Oil #3 at 212°F (100°C)</b> D 471 (ISO 175)					
Tensile Strength		+30%	+30%	+30%	+7%
Tensile Stress at 100% Elongation		-8%	-6%	-9%	-6%
Tensile Stress at 300% Elongation		+12%	+13%	+7%	+9%
Ultimate Elongation		+14%	+15%	+24%	+22%
Hardness, Shore D		-1	0	+1	-1
Volume		0%	+1%	+1%	+1%

# Texin<sup>®</sup> 285A

## Property Changes after Aging Texin 285A 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		+11%	+10%	+16%	+20%
Tensile Stress at 100% Elongation		-3%	-2%	+7%	+1%
Tensile Stress at 300% Elongation		-4%	-2%	+3%	-1%
Ultimate Elongation		+6%	-7%	+1%	+1%
Hardness, Shore D		-1	0	+1	-1
Volume		0%	+1%	+1%	+1%
<b>Fuel C at 73°F (23°C)</b>	D 471 (ISO 175)				
Tensile Strength		-18%	-20%	-18%	-18%
Tensile Stress at 100% Elongation		-7%	-6%	-7%	-6%
Tensile Stress at 300% Elongation		-20%	-20%	-19%	-18%
Ultimate Elongation		+4%	+3%	+4%	+4%
Hardness, Shore D		-5	-6	-5	-4
Volume		+23%	+24%	+24%	+24%

\* This table shows property changes for Texin 285A 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> 285A

**Note:**

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

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**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.

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