



**ISOTHANE® 5065D**  
**Thermoplastic Polyurethane**  
**Biocompatible Grade**

**Technical Data Sheet**

**Description**

ISOTHANE® 5065D resin is a polyether based thermoplastic polyurethane having high elasticity and recovery. It has excellent mechanical properties and good damping characteristics. ISOTHANE® 5065D can be processed by extrusion and injection molding.

**Supply and Storage**

ISOTHANE® TPU resins are supplied in pellet form packed in 25kg moisture proof bags. All TPU resins have been dried before packing. ISOTHANE® TPU resins should be stored in cool and dry environment in their original containers until be used. Storage temperature should not exceed 30°C. If only a portion of TPU resins was used from a bag, the remainder of TPU resins should be tightly closed.

**Drying**

TPU resins are hygroscopic and pre-drying of TPU resins is always a necessary step before processing. Depend on the climate, the granule exposed to the atmosphere will absorb moisture very quickly. The moisture might bring about partial degradation of polymers and the formation of bubbles or streaks in the molded and extruded parts. In order to ensure the efficient and successful processing into quality parts, the moisture content in TPU resins is recommended less than 0.02%.

A desiccant-bed-type hopper dryer is recommended for drying ISOTHANE® 5065D. The recommended drying conditions are 95°C (203°F) for 4-6 hours. The dew point of the inlet air should be in the range of -30 to -40°C.

**Processing— Extrusion**

- Barrel and Motor
  - ◆ High torque drive capacity at low speed
  - ◆ Vented or standard barrels acceptable

- Screw
  - ◆ Compression ratios between 2:1 and 3:1
  - ◆ Minimum L/D of 30/1
- Feed Throat
  - ◆ Vertical and tangential
  - ◆ Water cooling is recommended
- Screen Pack
  - ◆ Streamlined breaker plates with screen packing is recommended
  - ◆ Typical 40/80/80/40 mesh screens
- Die
  - ◆ Streamline with good temperature control
  - ◆ Land Length is generally 10 to 15 times the part thickness
  - ◆ Coat-hanger manifold-type dies are recommended for extruding film and sheet
  - ◆ Crosshead dies are recommended for wire, cable and hose jacketing
  - ◆ Side-fed rotating dies are recommended for blown film
- Extrusion Temperatures

Feeding Zone	Compression Zone	Metering Zone	Die
195~205°C	205~215°C	205~215°C	200~210°C

**Processing— Injection Molding**

- Barrel and Motor
  - ◆ High torque drive capacity at low speed
  - ◆ Vented or standard barrels acceptable
- Screw
  - ◆ Compression ratios between 2:1 and 3:1
  - ◆ Metering screw with gradual transition zone
- Injection Pressure
  - ◆ Typical 6,000 to 15,000 psi
  - ◆ Hold pressure 60 – 70% of forward time
- Injection speed
  - ◆ Slow to moderate
  - ◆ Depends on gating, wall section and flow

length

➤ Injection Molding Temperatures

Feeding Zone	Compression Zone	Metering Zone	Die
195~205°C	205~215°C	205~215°C	200~210°C

### Coloring

Generally, ISOTHANE® TPU resins are supplied in their natural color. They can be colored by blending with pigment or pigment master batch. Using master batch based on TPU is recommended. Other master batch based on polyethylene or polystyrene is suitable to a limited extent. All colorants employed in TPU resins must be pre-dried before processing.

The normal addition of pigment or pigment master batch is 0.2%-0.5% or 1-3%.

### Additives

Various additives can be used to enhanced the properties of ISOTHANE® TPU resins, e.g. anti-blocking agents, antioxidant, UV stabilizers or release agents. Most additives supplied as master batches are available. But not all additives are compatible with ISOTHANE® TPU resins. It is recommended to inquire of your suppliers or our technical service before compounding.

### Recycling

For ISOTHANE® TPU resins, up to 20% of regrind may be recycled with virgin material depending on finished parts requirements. The regrind material has to be kept free of contamination, diced and dried before re-using. The material which has been contaminated, discolored or degraded is not suitable for recycling. TPU resins may decrease desired properties, e.g. hardness and mechanical properties, due to improperly mixing with regrind.

Regulatory or testing organizations (e.g., UL) may have specific requirements limiting the allowance amount of regrind. Certain quality requirements laid down in specifications may exclude the use of regrind material.

### Healthy and Safety Information

Before working with these products, it is essential

that all operators are aware of the healthy and safety precautions. ISOTHANE® TPU resins can be processed or machined over a wide range of temperature. There can be some smoke formation during processing. The smoke that contains some decomposition substances of TPU or additives may cause irritation to human body. Generally, the temperature does not exceed 240°C that can reduce decomposition formation. An effective extraction system, especially in the melt outlet zone, is necessary. The detail information concerning healthy and safety can be available in safety data sheets (SDS) or contact our technical service.

### Disposal

ISOTHANE® TPU resins present no hazard to the environment or water. They can be dumped on municipal landfill or in a waste incineration plant. The official regulations on waste disposal should be observed.

## ISOTHANE® 5065D Properties:

Items	Units	Test Standard	5065D
Specific Gravity	g/cm <sup>3</sup>	ASTM D-792	1.17
Hardness	Shore D	ASTM D-2240	65D
Tensile Strength	MPa psi	ASTM D-412	53 7670
@ 100% elongation	MPa psi	ASTM D-412	40 5790
@ 300% elongation	MPa psi	ASTM D-412	49 7110
Elongation @ Break	%	ASTM D-412	340
Tear Strength	N/mm	ASTM D-624	270 1540
Flexural Modulus	MPa psi	ASTM D-790	420 60800
Melt Flow Rate	g/10min 224°C, 1.2kg	ASTM D-1238	5-15

While the above information is presented in good faith and believed to be accurate, GRECO does not guarantee satisfactory results from reliance upon such information and disclaims all liability for any loss or damage arising out of its use.

Updated in 08/2020

**GREAT EASTERN RESINS INDUSTRIAL CO.,LTD.**

35, 34 Road, Taichung Industrial Park, Taichung, Taiwan, R. O. C.

TEL: 886-4-2358-7676 FAX: 886-4-2358-1296

E-Mail: [sales2@greco.com.tw](mailto:sales2@greco.com.tw)