



TEXIN® STX-LG-40

High Modulus, 40% Glass-Fiber-Reinforced Thermoplastic Polyurethane

Description and Applications

Texin STX-LG-40 resin is a high performance glass-reinforced thermoplastic polyurethane which possesses an excellent combination of rigidity and toughness. This resin exhibits excellent heat and chemical resistance along with ease of processing and good surface appearance. Other key attributes of Texin STX-LG-40 TPU include low moisture absorption, low mold shrinkage, a low coefficient of thermal expansion, and good abrasion resistance. Designed for injection molding, this grade contains a nominal 40% glass fiber reinforcement.

Typical uses may include housings, fasteners, caster hbs and metal replacement applications. As with any product, use of Texin STX-LG-40 resin in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

Storage, Drying and Regrind Usage

Texin thermoplastic 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 temperatures should not exceed 95°F (35°C). Unused resin from opened containers, or reground material that is not to be used immediately, should be stored in sealed containers.

Prior to processing, Texin STX-LG-40 resin must be thoroughly dried in a desiccant dehumidifying hopper dryer for a minimum of 4 hours. Hopper inlet air temperature should be 220 - 250°F (104-121°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.

Where end-use requirements permit, up to 20% Texin resin regrind may be used with virgin material. Regrind material must be generated from properly molded/extruded parts, sprues, runners, trimmings, and/or films.

Degraded or discolored material may not be used for regrind. All regrind material must be free of contamination and thoroughly blended with virgin material prior to drying and processing. Finished parts containing regrind must be tested to ensure that end-use requirements are fully met.

Injection Molding and Extrusion Conditions

Typical starting conditions for injection molding and extrusion are noted below. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, part geometry, etc.

Typical Injection Molding Conditions

Barrel Temperatures:		
Rear	465°-485°F	(241°-252°C)
Middle	470°-490°F	(243°-254°C)
Front	470°-490°F	(243°-254°C)
Nozzle	470°-500°F	(243°-260°C)
Melt Temperature	460°-490°F	(238°-254°C)
Mold Temperature	110°-150°F	(43°-66°C)
Injection Pressure	8,000-16,000	psi
Hold Pressure	60-80% of Injection Pressure	
Back Pressure	800	psi max.
Screw Speed	40-80	rpm
Injection Speed	Moderate	
Cushion	1/8 inch	max

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

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

Regulatory Compliance Information

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

Health and Safety Information

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling Texin STX-LG-40 resin. Before working with this product, you must read and become familiar with the available information on its hazards, proper use and handling. This cannot be overemphasized. Information is available in several forms, e.g., material safety data sheets and product labels. Consult your Bayer MaterialScience representative or contact Bayer's Product Safety and Regulatory Affairs Department in Pittsburgh, PA.

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Typical Properties* For Natural Resin	ASTM Test Method (Other)	Units		Texin STX-LG-40 TPU	
		U.S. Conventional	SI Metric	U.S. Conventional	SI Metric
General					
Specific Gravity	D 792 (ISO 1183)			1.53	
Rockwell Hardness	D 785	M Scale/R Scale		94/121	
Water Absorption, 73°F (23°C)	D 570 (ISO 62)				
24 Hours		%		0.14	
7 Days		%		0.35	
Mold Shrinkage at 100-mil Thickness: Flow Direction	D 955 (ISO 2577)	in/in (mm/mm)		0.002	
Mechanical					
Tensile Stress at Break	D 638	lb/in ²	MPa	24,680	170
Tensile Elongation at Break	D 638	%		2.6	
Tensile Modulus	D 638	lb/in ²	MPa	1,430,000	9,860
Flexural Modulus	D 790 (ISO 178)	lb/in ²	MPa	1,440,000	9,930
Flexural Stress (Maximum)	D 790 (ISO 178)	lb/in ²	MPa	42,900	296
Strain at Maximum Stress	D 790 (ISO 178)	%		3.2	
Un-notched Izod Impact Strength 73°F (23°C) 0.125 in thickness	D 4812	ft•lb/in	J/m	19.4	1,036
Notched Izod Impact Strength Un-annealed (Annealed**) 73°F (23°C) 0.125 in thickness	D 256	ft•lb/in	J/m	5.9 (6.7)	313 (357)
-22°F (-30°C) 0.125 in thickness		ft•lb/in	J/m	5.2	275
Thermal					
Heat Deflection Temperature, Un-annealed (Annealed**)	D 648				
264 psi (1.82 MPa) 0.250 in Thickness		°F	°C	227 (235)	108 (112)
66 psi (0.46 MPa) 0.250 in Thickness		°F	°C	257 (382)	125 (195)
Vicat Softening Temperature, (10 N,50 °C/hr), Un-annealed	D 1525 (ISO 306)	°F	°C	409	209
Coefficient of Linear Thermal Expansion (CLTE)	D 696	in/in/°F	mm/mm/ °C	1.58E-5	2.85E-5

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** Post-cured for 2 hours at 230°F (110°C).

