



**International
Standard**

ISO 16365-1

**Plastics — Thermoplastic
polyurethanes for moulding and
extrusion —**

**Part 1:
Designation system and basis for
specifications**

*Plastiques — Polyuréthannes thermoplastiques pour moulage et
extrusion —*

Partie 1: Système de désignation et base de spécifications

**Second edition
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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

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Contents

	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Designation system	2
4.1 General.....	2
4.2 Data block 1.....	3
4.3 Data block 2.....	3
4.4 Data block 3.....	4
4.5 Data Block 4.....	5
4.5.1 General.....	5
4.5.2 Hardness.....	5
4.5.3 Tensile modulus of elasticity.....	6
4.6 Data block 5.....	6
5 Examples of designations	7
Bibliography	8

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 9, *Thermoplastic materials*.

This second edition cancels and replaces the first edition (ISO 16365-1:2014), which has been technically revised.

The main changes are as follows:

- the range of hardness Shore A in [Table 4](#) has been modified.

A list of all parts in the ISO 16365 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

This document is based on the ISO 1043 series and ISO 11469.

The types of thermoplastic polyurethane are differentiated from each other by a classification system based on appropriate levels of the designatory properties:

- a) hardness;
- b) tensile modulus of elasticity (optional);

and on information about the alternating hard and soft segments in the main chain, the intended application and/or method of processing, important properties, additives, colour, fillers and reinforcing materials.

In order to specify a thermoplastic elastomer for a particular application or reproducible processing, additional requirements are given in data block 5 (see [4.1](#) and [4.6](#)).

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Plastics — Thermoplastic polyurethanes for moulding and extrusion —

Part 1: Designation system and basis for specifications

1 Scope

This document establishes a system of designation for thermoplastic polyurethane elastomers.

The designation system can be used as the basis for specifications.

The designation system is applicable to all thermoplastic polyurethane elastomers. It applies to materials ready for normal use in the form of powder, granules or pellets, unmodified or modified by colourants, fillers or other additives, etc.

This document does not intend to imply that materials having the same designation give necessarily the same performance. This document does not provide engineering data, performance data, or data on processing conditions which might be required to specify a material for a particular application and/or method of processing.

NOTE If such additional properties are required, they can be determined according to the test methods specified in ISO 16365-2, if suitable.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 527 (all parts), *Plastics — Determination of tensile properties*

ISO 868, *Plastics and ebonite — Determination of indentation hardness by means of a durometer (Shore hardness)*

ISO 1043-4, *Plastics — Symbols and abbreviated terms — Part 4: Flame retardants*

ISO 18064, *Thermoplastic elastomers — Nomenclature and abbreviated terms*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Designation system

4.1 General

The designation system for polyurethanes is based on the following standardized pattern (see [Table 1](#)).

Table 1 — Data block designation system

Designation						
Description block (optional)	Identity Block					
	International Standard Block	Individual Item Block				
		Data Block 1	Data Block 2	Data Block 3	Data Block 4	Data Block 5

The designation consists of an optional description block, reading “Thermoplastics”, and an identity block comprising the International Standard number and an individual item block. For unambiguous designation, the individual item block shall be subdivided into five data blocks comprising the following information.

- Data block 1: Identification of the thermoplastic polyurethane by its abbreviated symbol (TPU), in accordance with ISO 18064, and optional information on the alternating hard and soft segments in the main chain (see [4.2](#)).
- Data block 2: Fillers or reinforcing materials including summarized nominal content (see [4.3](#)):
 - important properties, modifier, and flame retardant (see [4.3](#));
 - declaration of recycle: R followed by a number representing the percentage by mass of recycle (see [4.3](#)).
- Data block 3: Application and processing:
 - Position 1: method of processing (see [4.4](#));
 - Positions 2 and further: additives, supplementary information and other characteristics (see [4.4](#)).
- Data block 4: Designatory properties (see [4.5](#)):
 - hardness;
 - modulus.
- Data block 5: For the purpose of specifications, a fifth data block containing additional information may be used (see [4.6](#)). The kind of information and the code-letters used are not the subject of this document.

The first character of the individual item block shall be a hyphen.

The five data blocks shall be separated from each other by a comma.

If a data block is not used, this shall be indicated by doubling the separation sign, i.e. by two commas (,,). Terminal commas may be omitted.

For part marking the first two data blocks of the designation are used, connected with a hyphen, and placed between the punctuation marks ‘>’ and ‘<’, where no spaces are used between the codes.

Designation										
Description block (optional)	Identity block									
	International Standard	Individual item block								
		Data block 1		Data block 2			Data block 3		Data block 4	Data block 5
		Polymer		Performance and origin			Application and processing		Properties	Additional information
		Type	Segment (optional)	Filler	Flame retardant	Recy-clate	Pro-cessing	Characteris-tics		
Thermo-plastics	16365	TPU	-ARES	(GF+MD) 35	FR(3)	R50	M	A	40-75	
> Part marking <										
No	No	Yes		Yes			No		No	No

Designation: ISO 16365-TPU,(GF+MD)35 FR(30) (R50),MA,40-75,,

4.2 Data block 1

In this data block, after the hyphen, the thermoplastic polyurethane is identified by using the symbols and designations specified below.

The prefix TP shall be followed by a letter representing the category of the thermoplastic elastomer as detailed in ISO 18064. For urethane thermoplastic elastomers, the prefix TP is followed by the letter U.

Thermoplastic polyurethanes consist of a block copolymer of alternating hard and soft segments with urethane chemical linkages in the hard blocks and ether, ester, or carbonate linkages or mixtures of them in the soft blocks. The “TPU” group is sub-categorized into groups according to the linkages in the soft blocks. The following symbols shall be used:

- TPU-ARES: Aromatic isocyanate, polyester polyol;
- TPU-ARET: Aromatic isocyanate, polyether polyol;
- TPU-AREE: Aromatic isocyanate, polyol with ester and ether linkages;
- TPU-ARCE: Aromatic isocyanate, polycarbonate polyol;
- TPU-ARCL: Aromatic isocyanate, polycaprolactone polyol;
- TPU-ALES: Aliphatic isocyanate, polyester polyol;
- TPU-ALET: Aliphatic isocyanate, polyether polyol.

The identification of the subcategories by the above-mentioned symbols is optional.

4.3 Data block 2

In this data block, the type of filler or reinforcing material is represented by a single code-letter and its physical form by a second code-letter, the code-letters as specified in [Table 2](#). Subsequently (without a space), the mass content may be given by a two-figure code-number.

Mixtures of filler materials or forms may be indicated by combining the relevant codes using the sign “+” within parentheses followed by the total filler content outside the parenthesis. For example, a mixture of 25 % by mass glass fibre (GF) and 10 % by mass mineral powder (MD) shall be indicated by (GF+MD)35.

Separated from the reinforcement code by a space, the addition of a flame retardant or flame retardant behaviour is represented by the code FR, where the type of flame retardant in accordance with ISO 1043-4 shall be given by a two letter-code between parentheses.

Separated by a space from the flame retardant or the reinforcement code if no flame retardant code is used, the declaration of recyclate is represented by the code, R, between parentheses, (R). Following the code, R, the mass content may be given between the parenthesis without a space. For example, a TPU material containing 20 % glass fibres resulting from an overall minimum 70 % of mass recyclate and 30 % of virgin material would be indicated TPU-GF20 (R70).

Table 2 — Coding system for fillers and reinforcing materials in data block 2

Code-letter	Material (Position 1)	Form (Position 2)
B	Boron	Balls, beads, spheres
C	Carbon ^a	
D		Powder, dry blend
F		Fiber
G	Glass	Granules, ground
H		Whiskers
K	Calcium carbonate (CaCO ₃)	
M	Mineral ^a	
ME	Metal ^b	
S	Organic, synthetic	
T	Talc	
X	Not specified	Not specified
Z	Others ^a	Others

^a These materials may be identified after the code-letter, e.g. by chemical symbol or additional codes to be agreed upon.

^b Metal filler shall be identified by the chemical symbol (in capital letters) after the mass content. For example, steel whiskers may be designated “MEH05FE”.

4.4 Data block 3

In this data block, information about intended applications or method of processing is represented by a code-letter, followed by code-letters describing additives, supplementary information, and other characteristics. The code-letters are specified in [Table 3](#).

If no specific information is given on the method of processing the letter X shall be used as the first code-letter.

Table 3 — Codes used in data block 3

Code-letter	First letter	Letters 2 to 8
A	Adhesive	Processing stabilized
B	Blow moulding	Antiblocking
C	Calendering	Coloured
D	Disc manufacture	Powder
E	Extrusion	Expandable
F	Extrusion of films	Special burning characteristics
G	General use	Granules
H	Coating	Heat stabilized
K	Cable and wire coating	
L	Monofilament extrusion	Light and/or weather stabilized

Table 3 (continued)

Code-letter	First letter	Letters 2 to 8
M	Moulding	Nucleated
N	Multiple processing modes	Natural (no colour added)
O		Stabilized against oxidation
R	Rotational moulding	Mould release agent
S		Lubricated
T		Transparent
W		Stabilized against hydrolysis
X	No indication	
Z		Antistatic

4.5 Data Block 4

4.5.1 General

In this data block, the hardness is represented by a 2-figure code-number (see 4.5.2) and the tensile modulus of elasticity by a 3-figure code-number (see 4.5.3). The code-numbers are separated from each other by hyphens.

If no specific information is given in one of the two positions, the letter X shall be used.

If a property value falls on or near a range limit, the manufacturer shall state which range will designate the material. If subsequent individual test values lie on, or on either side of, the limit because of manufacturing tolerances, the designation is not affected.

NOTE Not all combinations of the values of the designatory properties are provided by currently available polymers.

4.5.2 Hardness

The Shore hardness shall be determined in accordance with ISO 868.

The possible values of the hardness are divided into 16 ranges, each represented by a 2-figure code-number as specified in Table 4.

Table 4 — Code-numbers used for hardness in data block 4

Code-number	Range of hardness Shore D	Range of hardness Shore A (indication)
05	≤ 7	$\leq 35A$
10	>7 but ≤ 12	$> 35A$ but $\leq 45A$
15	>12 but ≤ 17	$> 45A$ but $\leq 56A$
20	>17 but ≤ 22	$> 56A$ but $\leq 67A$
25	>22 but ≤ 27	$> 67A$ but $\leq 75A$
30	>27 but ≤ 32	$> 75A$ but $\leq 81A$
35	>32 but ≤ 37	$> 81A$ but $\leq 86A$

NOTE The hardness of thermoplastic elastomers is measured in Shore A and Shore D according to ISO 868. Shore hardness measures a material's resistance to the penetration of a needle under a defined spring force. It is determined as a number from 0 to 100 on the scales A or D. The higher the number, the higher the hardness of the material. The Shore A is used for (very) flexible types and the Shore D for flexible and more rigid types. The Shore A and D ranges do overlap. Therefore, for designation purposes a parameter combining the hardness ranges of the Shore A and D is used as this scale which covers the whole range and is able to discriminate between rather flexible, medium and rigid materials. For values around and above 50, this parameter is identical to the Shore D hardness.

Table 4 (continued)

Code-number	Range of hardness Shore D	Range of hardness Shore A (indication)
40	>37 but ≤42	> 86A but ≤90A
45	>42 but ≤47	> 90A but ≤95A
50	>47 but ≤52	>95A
55	>52 but ≤57	
60	>57 but ≤62	
65	>62 but ≤67	
70	>67 but ≤72	
75	>72 but ≤77	
80	>77	

NOTE The hardness of thermoplastic elastomers is measured in Shore A and Shore D according to ISO 868. Shore hardness measures a material's resistance to the penetration of a needle under a defined spring force. It is determined as a number from 0 to 100 on the scales A or D. The higher the number, the higher the hardness of the material. The Shore A is used for (very) flexible types and the Shore D for flexible and more rigid types. The Shore A and D ranges do overlap. Therefore, for designation purposes a parameter combining the hardness ranges of the Shore A and D is used as this scale which covers the whole range and is able to discriminate between rather flexible, medium and rigid materials. For values around and above 50, this parameter is identical to the Shore D hardness.

4.5.3 Tensile modulus of elasticity

The tensile modulus of elasticity shall be determined in accordance with the ISO 527 series.

The possible values of the tensile modulus of elasticity are divided into 10 ranges, each represented by a 3-figure code-number as specified in [Table 5](#).

Table 5 — Code-numbers used for tensile modulus of elasticity in data block 4

Code-number	Range of modulus MPa
002	≤30
004	>30 but ≤50
006	>50 but ≤70
008	>70 but ≤90
010	>90 but ≤110
015	>110 but ≤200
025	>200 but ≤300
040	>300 but ≤500
075	>500 but ≤1 000
200	>1 000 but ≤3 000
400	>3 000 but ≤6 000
800	>6 000 but ≤10 000
999	>10 000

4.6 Data block 5

Indication of additional requirements in optional data block 5 is a way of transforming the designation of a material into a specification for a particular application. This may be done for example by reference to a suitable national standard or to a standard-like, generally established specification (see [Clause 5](#)).