

Dawnprene TPE 6002-NA

TPE

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Features:

A soft,natural, thermoplastic elastomer (TPE) family. This material combines good physical properties,chemical resitance and elasticity, designed for injection applications.This grade of TPE can be processed on conventional thermoplastics equipment for injection or blow molding.It is completely recyclable.

(GENERAL)			
(Application)	* PA66 general injection		
RoHS Compliance	RoHS		
(Color)	Natural		
(Form)	Pellet		
(Processing Method)	(injection)		
(Revision Date)	2016-12-22		
Physical	Typical Value	Unit	Test Method
(Density)	0.98	g/cm ³	ASTM D792
(Hardness)			
Shore Hardness(Shore A, 10 sec,2	58	A	ASTM D2240
(Mechanical Property)			
100% - 2	1.7	Mpa	ASTM D412
- 2	7.0	Mpa	ASTM D412
Tensile strength-parallel flow direction 2	740	%	ASTM D412
- 2	29	KN/m	ASTM D624
0.01%			
Drying Instructions: Need drying the granules before make molding,excessive moisture will lead materials bad extrusion surface,mechanical performance reduction and bad surface appearance. Moisture content request below 0.01%,suggesting drying as follow process:			
Drying conditions	Dring temperature/		Dring time/h
first choice	80 90		2 3
other choice	100		1
110	105		
If drying temperature over than 110 ,it might cause materials blocking in barrel zone;if use moisture analysis meter,the temperture setting should be on 105 .			



Screw Speed R	Zone I	Zone II	Zone III	Zone IV	Zone V	Nozzl or Die	Mould
4	17 180	220-240	230-250	235-255	235-255	220-245	50-70

1. Dawnprene TPE PVC

Dawnprene TPE is incompatible with PVC materials, hence must clean the equipment before using.

2. 150 150 2 , .
Above testing data is tested by molding sample block, cutting by the sheet size is 150 150 2 .

3. 25% Compression Set 25%

4. .
The properties is typical performance, is not regarding as technical index or agreement.

5. Any reprocessing must follow the above instructions, and ensure no content impurity.

6. Above instructions for reference only, different equipment might have difference parameters, please adjust accordingly with different mold and product shape.

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