

## Dawnflex TPU DN-1085-T1

25kg/			
		1.20	g/cm <sup>3</sup>
		86 1	A
		35	MPa
100%		6	MPa
300%		12	MPa
		600	%
		115	KN/m
射 0.05%			
100			
100			
		/	/h
		90-100	2-4
对	205-215	对	190-200
	200-205		190-200
	195-200		185-195
	195-200		180-190
SDS			
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General information			
Material Properties	Good formability, high transparency, low precipitation risk, easy to post-processing		
Application Market	Electronic injection molding, pneumatic tubing, modification, shoe materials		
Appearance Shape	Transparent particles		
Packing Specifications	25 kg/bag		
Processing Method	Injection Extrusion		
Physical property parameters	<b>Typical value</b>	<b>Unit</b>	<b>Method</b>
Density	1.20	g/cm <sup>3</sup>	ASTM D792
Shore Hardness	86 1	A	ASTM D2240
Tensile Strength	35	MPa	ASTM D412
100% Modulus	6	MPa	ASTM D412
300% Modulus	12	MPa	ASTM D412
Elongation at Break	600	%	ASTM D412
Tear Strength	115	KN/m	ASTM D624
Processing suggestions			
<b>Processing conditions</b> 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 0.05%, suggesting drying as follow process:			
Drying conditions	Drying temperature/		Drying time/h
	90-100		2-4
Processing temperature			
Injection	Set Value	Extrusion	Set Value
Nozzle ( )	205-215	Nozzle ( )	190-200
Front Barrel ( )	200-205	Front Barrel ( )	190-200
Middle Barrel ( )	195-200	Middle Barrel ( )	185-195
Rear Barrel ( )	195-200	Rear Barrel ( )	180-190
<b>Healthy &amp; Safety &amp; Environmental:</b> Take SDS for reference			
<b>Extra information</b> 1.The above properties are typical performance which is not regarding as technical index or agreement. 2.Above instructions for reference only, different equipment might have difference parameters, please adjust accordingly with different mold and product shape.			
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