

Dawnflex TPU DN-1385-T1

	25kg/		
	1.20	g/cm ³	ASTM D792
	85± 2	A	ASTM D2240
	32	MPa	ASTM D412
100%	5	MPa	ASTM D412
300%	10	MPa	ASTM D412
	600	%	ASTM D412
	120	KN/m	ASTM D624

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General information			
Material Properties	Good formability, high transparency, easy to post-processing		
Application Market	Modifications, shoe materials, injection molded products		
Appearance Shape	Transparent particles		
Packing Specifications	25 kg/bag		
Processing Method	Injection Extrusion		
Physical property parameters	Typical value	Unit	Method
Density	1.20	g/cm ³	ASTM D792
Shore Hardness	85± 2	A	ASTM D2240
Tensile Strength	32	MPa	ASTM D412
100% Modulus	5	MPa	ASTM D412
300% Modulus	10	MPa	ASTM D412
Elongation at Break	600	%	ASTM D412
Tear Strength	120	KN/m	ASTM D624
Processing suggestions			
Processing conditions			
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 ()	210-220	Nozzle ()	190-200
Front Barrel ()	205-210	Front Barrel ()	190-200
Middle Barrel ()	200-205	Middle Barrel ()	185-195
Rear Barrel ()	200-205	Rear Barrel ()	180-190
Healthy & Safety & Environmental: Take SDS for reference			
Extra information			
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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