



Dawnprene TPV 34-85A

Features:

A soft, color thermoplastic vulcanized (TPV) in the thermoplastic elastomer (TPE) family. This material combines good physical properties, chemical resistance elasticity, designed for injection applications. This grade of TPV can be processed on conventional thermoplastics equipment for injection molding. It is polyolefin based and completely recyclable.

FEATURES			
Application	Injection		
RoHS Compliance	RoHS		
Color	Black		
Form	Pellet		
Molding method	* Injection		
Revise date	2018-5-15		
Physical Properties	Typical Value	Unit	Test Standard
Density	0.934	g/cm ³	ISO 1183
Shrinkage Crossflow	1.26	%	ISO 294
Shrinkage Flow	1.08	%	ISO 294
Hardness			
Shore Hardness (Shore A,15 sec,23)	88	A	ISO 868
Mechanical Property			
Tensile Stress at Break Type 1 dumbbell, 500mm/minute	14	Mpa	ISO 37
Elongation at Break Type 1 dumbbell, 500mm/minute	685	%	ISO 37
Tensile Stress at 100% Elongation Type 1 dumbbell, 500mm/minute	4.86	Mpa	ISO 37
Tear strength – Method B, angle die,500 mm/minute	71	KN/m	ISO 34-1
Compression set 70 ,22hr,Type A	46	%	ISO 815
Compression set 125 ,70hr,Type A	64	%	ISO 815
Thermal Properties			
Low Temperature Brittleness	-50		ISO 812,Type B
Ozone Resistance Procedure A 100 pphm,40	Zero Rating	--	ISO1431-1
MFR 230 5kg	37.2	g/10min	ISO 1133
Long time reliable temperature	-40~125		--
Short time contact temperature	-55~150		--
Flammability			
Burning Rate	20	mm/min	GB/T8410
Molding Method			
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/hour	
first choice	80 90	2 3	
other choice	100	1	
If drying temperature over than 110 ,it might cause materials blocking in barrel zone; if use moisture analysis meter, the temperature setting should be on 105 .			



Screw Speed R	Zone I	Zone II	Zone III	Zone IV	Zone V	Nozzle
40-150	160-170	180-185	190-220	190-225	180-225	170-195

Addition Information

1. Dawnprene TPV is incompatible with PVC materials, hence must clean the equipment before using.
2. Above testing data is tested by injeciton sample block, cutting by the sheet size is 120 × 100 × 2 .
- 3.Compression Set 15%
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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