

Dawnflex TPU DN-1098-T1

25kg/			
	1.23	g/cm ³	ASTM D792
	98 1	A	ASTM D2240
	37	MPa	ASTM D412
100%	15	MPa	ASTM D412
300%	20	MPa	ASTM D412
	450	%	ASTM D412
180	3685.844	KN/m	ASTM D624

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General information			
Material Properties	Good formability and high mechanical properties		
Application Market	Electronic protection cover, Shoes, Casters, Injection molded products		
Appearance Shape	Transparent particles		
Packing Specifications	25 kg/bag		
Processing Method	Injection Extrusion		
Physical property parameters	Typical value	Unit	Method
Density	1.23	g/cm ³	ASTM D792
Shore Hardness	98 1	A	ASTM D2240
Tensile Strength	37	MPa	ASTM D412
100% Modulus	15	MPa	ASTM D412
300% Modulus	20	MPa	ASTM D412
Elongation at Break	450	%	ASTM D412
Tear Strength	180	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 ()	225-235	Nozzle ()	195-205
Front Barrel ()	220-230	Front Barrel ()	190-200
Middle Barrel ()	215-225	Middle Barrel ()	185-195
Rear Barrel ()	215-225	Rear Barrel ()	185-195
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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