

Dawnflex TPU DN-1095-T1

25kg/			
1.21		g/cm ³	ASTM D792
96 1		A	ASTM D2240
42		MPa	ASTM D412
100%	15	MPa	ASTM D412
300%	22	MPa	ASTM D412
450		%	ASTM D412
150		KN/m	ASTM D624
0.05%			
100			
100			
		/	/h
		90-100	2-4
220-230			200-210

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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	1.21	g/cm ³	ASTM D792
Shore Hardness	96 1	A	ASTM D2240
Tensile Strength	42	MPa	ASTM D412
100% Modulus	15	MPa	ASTM D412
300% Modulus	22	MPa	ASTM D412
Elongation at Break	450	%	ASTM D412
Tear Strength	150	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	220-230	Nozzle	200-210
Front Barrel	215-225	Front Barrel	190-200
Middle Barrel	210-220	Middle Barrel	185-195
Rear Barrel	210-220	Rear Barrel	185-190
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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