

Dawnflex TPU DN-1380-T1

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General information			
Material Properties	Good formability, high transparency, low precipitation risk, 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	83 1	A	ASTM D2240
Tensile Strength	28	MPa	ASTM D412
100% Modulus	5	MPa	ASTM D412
300% Modulus	8	MPa	ASTM D412
Elongation at Break	650	%	ASTM D412
Tear Strength	90	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
	80-90		2-4
Processing temperature			
Injection	Set Value	Extrusion	Set Value
Nozzle	175-185	Nozzle	170-180
Front Barrel	170-180	Front Barrel	165-175
Middle Barrel	165-175	Middle Barrel	160-170
Rear Barrel	160-		