

Dawnflex TPU DN-3060-T1

General information			
Material Properties	High transparency, fast molding, low precipitation, good low temperature resistance, high mechanical strength		
Application Market	Over molding, modified, shoes, pipes		
Appearance Shape	Transparent particles		
Packing Specifications	25 kg/bag		
Processing Method	Injection Extrusion		
Physical property parameters	Typical value	Unit	Method
Density	1.18	g/cm ³	ASTM D792
Shore Hardness	65 2	A	ASTM D2240
Tensile Strength	30	MPa	ASTM D412
100% Modulus	2	MPa	ASTM D412
300% Modulus	4	MPa	ASTM D412
Elongation at Break	1000	%	ASTM D412
Tear Strength	80	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	195-205	Nozzle	180-190
Front Barrel	190-200	Front Barrel	180-190
Middle Barrel	185-195	Middle Barrel	175-185
Rear Barrel	185-195	Rear Barrel	170-180
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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