



## Dawnflex TPU DN-1085-T2

General information			
Material Properties	Good formability, high transparency, low precipitation risk, easy to post-processing		
Application Market	Electronic injection molding, pneumatic tubing, modification, shoe materials		
Appearance Shape	Transparent particles		
Packing Specifications	25 kg/bag		
Processing Method	Injection Extrusion		
Physical property parameters	<b>Typical value</b>	<b>Unit</b>	<b>Method</b>
Density	1.20	g/cm <sup>3</sup>	ASTM D792
Shore Hardness	86± 1	A	ASTM D2240
Tensile Strength	36	MPa	ASTM D412
100% Modulus	7	MPa	ASTM D412
300% Modulus	12	MPa	ASTM D412
Elongation at Break	600	%	ASTM D412
Tear Strength	115	KN/m	ASTM D624
Processing suggestions			
<b>Processing conditions</b> 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	205-215	Nozzle	190-200
Front Barrel	200-205	Front Barrel	190-200
Middle Barrel	195-200	Middle Barrel	185-195
Rear Barrel	195-200	Rear Barrel	180-190
<b>Healthy Safety Environmental:</b> Take SDS for reference			
<b>Extra information</b> 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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