



## Dawnflex TPU DN-3595-T1

General information			
Material Properties	High transparency, low precipitation risk, easy to post-processing, high strength.		
Application Market	Shoes, pipes, modified, cables		
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	1.21	g/cm <sup>3</sup>	ASTM D792
Shore Hardness	95 2	A	ASTM D2240
Tensile Strength	45	MPa	ASTM D412
100% Modulus	15	MPa	ASTM D412
300% Modulus	25	MPa	ASTM D412
Elongation at Break	550	%	ASTM D412
Tear Strength	160	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	210-220	Nozzle	190-200
Front Barrel	205-215	Front Barrel	190-200
Middle Barrel	205-215	Middle Barrel	185-195
Rear Barrel	200-210	Rear Barrel	180-190
<b>Healthy &amp; Safety &amp; 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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