

## Dawnflex TPU DN-1090-T1

25kg/			
1.20		g/cm <sup>3</sup>	ASTM D792
93 1		A	ASTM D2240
40		MPa	ASTM D412
100%	10	MPa	ASTM D412
300%	15	MPa	ASTM D412
550		%	ASTM D412
140		KN/m	ASTM D624
0.05%			
100			
100			
		/	/h
		90-100	2-4
210-220			195-205
205-215			190-200
205-215			190-200
200-210			185-195
SDS			
1.			
2.			
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( ) 0086-535-8868588;( )0086-535-8833988			

## Dawnflex TPU DN-1090-T1

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	93 1	A	ASTM D2240
Tensile Strength	40	MPa	ASTM D412
100% Modulus	10	MPa	ASTM D412
300% Modulus	15	MPa	ASTM D412
Elongation at Break	550	%	ASTM D412
Tear Strength	140	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	195-205
Front Barrel	205-215	Front Barrel	190-200
Middle Barrel	205-215	Middle Barrel	190-200
Rear Barrel	200-210	Rear Barrel	185-195

**Healthy & Safety & Environmental:** Take SDS for reference