

Dawnprene TPE 4001-PA

TPE

TPE

Features:

A soft thermoplastic elastomer (TPE) family. This material combines good physical properties,chemical resisittance and elasticity, designed for injection applications.This grade of TPE can be processed on conventional thermoplastics equipment for injection or blow molding.It is completely recyclable.

(GENERAL)		
(Application)	general injection	
RoHS Compliance	RoHS	
(Colour)	(Black)	
(Form)	Pellet	
(Processing Method)	(injection)	
(Revision Date)	2021-03-09	

Physical	Typical Value	Unit	Test Method
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200PPHM 23			No crack																				
0.1%																							
Drying Instructions: No broken bags do not need to dry ,if there is broken bags,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 0.1%,suggesting drying as follow process:																							
Drying conditions		Dring temperature/			Dring time/h																		
first choice		70 80			2 3																		
other choice		90			1																		
110				105																			
If drying temperature over than 110 ,it might cause materials blocking in barrel zone;if use moisture analysis meter,the temperture setting should be on 105 .																							
 <table><tr><th>Screw Speed R</th><th>Zone I</th><th>Zone II</th><th>Zone III</th><th>Zone IV</th><th>Zone V</th><th>Nozzl or Die</th><th>Mould</th></tr><tr><td>4</td><td>17 220</td><td>180-230</td><td>180-230</td><td>180-230</td><td>180-230</td><td>180-230</td><td>50-70</td></tr></table>								Screw Speed R	Zone I	Zone II	Zone III	Zone IV	Zone V	Nozzl or Die	Mould	4	17 220	180-230	180-230	180-230	180-230	180-230	50-70
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1.Dawnprene TPE PVC																							
Dawnprene TPE is incompatible with PVC mateials,hence must clean the equipment before using.																							
2. 120 100 2 , .																							
Above testing data is tested by molding sample block, cutting by the sheet size is 150 150 2 .																							
3. 50% Compression Set 50%																							
4.																							
The properties is typical performance,is not regarding as technical index or agreement.																							
5.																							
Any reprocessing must follow the above instructions,and ensure no content impurity.																							
6.																							
Above instructions for reference only,different equipment might have difference parameters,please adjust accordingly with different mold and product shape.																							
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