

Dawnprene TPV 10 series

一种需干燥料的 TPV 材料。

This series is one kind of TPV material need dry in advance.

材料适用于注塑、吹塑和其他加工方式，有良好的加工性能，制品表面手感光滑、细腻，兼具有高、低温抗性及抗老化性能。

This series of materials can be used for injection , blow molding and other molding methods; material processing performance is good,the product appearance is exquisite, feel good.

High and low temperature resistance and aging resistance.

材料主要应用于注塑应用，注塑和吹塑级产品。

This series of materials are mainly used for the injection application,injection molding and blow molding products.

Performance data sheet

Type properties 典型性能	Test Method 测试方法	Unit 单位	10-45A	10-55A	10-60A	10-64A	10-65A	10-70A	10-73A	10-80A	10-95A
Physical Property 物理性能											
Hardness 硬度	ISO7619	A	45	58	62	66	67	71	75	82	96
MFR (230℃, 5kg) 熔指	GB/T3682	g/10min	3.0	1.5	60	4.0	10	135	6.0	3.0	45
Density 密度	ISO1183	g/cm3	0.94	0.96	0.98	0.95	0.97	0.97	0.96	0.95	0.94
Mechanical Property 力学性能											
Tensile Strength 拉伸强度	ISO37	MPa	3.8	5.5	5.6	5.6	6.8	5.7	8.0	8.8	12.8
Elongation@bk 断裂伸长率	ISO37	%	450	450	400	460	550	410	460	510	600
100% Steching strength 100%定伸强度	ISO37	MPa	1.0	2.2	2.3	2.4	2.6	2.8	3.0	3.8	6.8
Tear Strength 撕裂强度	ISO34-1	KN/m	22	39	30	36	38	35	40	55	85
Compression set 压缩永久变形	ISO815	%	30	30	31	34	36	35	37	42	60
Heat Aging Property 热老化性能											
Hardness change 硬度变化	ISO188 1000hrs at 100℃	A	+3	+2	+3	+2	+2	+3	+2	+1	+1
Tensile strength change 拉伸强度变化率		%	-13	-12	-18	-11	-8	-12	-8	-6	-13
Elongation@bK 断裂伸长率变化率		%	-14	-16	-20	-14	-10	-16	-9	-8	-16
Brittle temperature 低温脆化温度	ASTMD746	℃	-60	-60	-60	-59	-58	-56	-56	-53	-48
Xenon lamp Property 氙灯老化性能											
Gray scale 灰度级别	PV1303 650h	/	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Appearance 外观		/	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过
Application 应用	/	/	Injections 注塑产品	Injections 注塑产品	Comer window 注塑角窗	Injections 注塑产品	Injections 注塑产品	Comer window 注塑角窗	Injections 注塑产品	Injections 注塑产品	Injections 注塑产品

Drying Instructions 干燥说明:

Need drying the granules before make molding,excessive moisture will lead materials bad injection surface mechanical performance reduction and bad surface appearance. Moisture content request below 0.05%.

在加工前需对料粒进行干燥，水分过高会导致材料注塑外观不良、机械性能下降及制品表面外观差。水分含量应小于0.05%。

Suggesting drying as follow process 干燥工艺建议如下:

Drying conditions 干燥条件	Drying temperature/℃ 干燥温度/℃	Drying time/h 干燥时间/时
first choice 首选	80~90	2~3
other choice 备选	100	1

Processing guide 加工参考

rpm 螺杆转速	Zone1 一区	Zone2 二区	Zone3 三区	Zone4 四区	Zone5 五区	Nozzle 喷嘴
40-150	160-190	180-205	190-220	190-235	180-225	170-205

Addition:

附:

Dawnprene TPV is incompatible with PVC materials,hence must clean the equipment before using.

Dawnprene TPV 与 PVC 等材料不相容，因此使用前必须清理设备。

Above testing data is tested by injection or mold sample block, cutting by the sheet size is 120 mm×100 mm×2 mm .

上述测试数据是采用注塑或模压试片，尺寸为 120 mm×100 mm×2 mm,裁制而成。

The properties is typical performance,is not regarding as technical index or agreement.

该性能为典型性能，不作为技术指标或协议。

Any reprocessing must follow the above instructions,and ensure no content impurity.

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Above instructions for reference only,different equipment might have difference parameters,please adjust accordingly with different mold and product shape.

以上工艺仅供参考，设备不同工艺参数也不同，请根据模具与制品形状具体调整。

Dawnprene TPV 10 /14 series

Abstract 概述

This series is one kind of TPV material need dry in advance.

一种需烘干的 TPV 材料。

Characteristic introduction 特性介绍

This series of materials can be used for injection , blow molding and other molding methods; material processing performance is good, the product appearance is exquisite, feel good. High and low temperature resistance and aging resistance.

材料适用于注塑、吹塑和其他加工方式，有良好的加工性能，制品表面手感光滑、细腻，兼具有高、低温抗性及抗老化性能。

Successful application 成功应用

This series of materials are mainly used for the injection application, injection molding and blow molding products

材料主要应用于注塑应用，注塑和吹塑级产品。

Performance data sheet

Type properties 典型性能	Test Method 测试方法	Unit 单位	14-50A	14-55A	14-60A	14-65A	14-69A	14-75A	14-80A	14-85A	14-90A	14-95A
Physical Property 物理性能												
Hardness 硬度	ISO7619	A	52	58	62	67	69	77	80	89	90	96
MFR (230°C, 5kg) 熔指	GB/T3682	g/10min	95	85	60	220	120	8.0	60	200	35	180
Density 密度	ISO1183	g/cm ³	1.04	0.96	0.95	0.95	0.96	0.97	0.94	0.93	0.98	0.95
Mechanical Property 力学性能												
Tensile Strength 拉伸强度	ISO37	MPa	4.4	4.8	5.5	5.5	5.8	8.5	7.7	9.8	12.0	13.0
Elongation@bk 断裂伸长率	ISO37	%	650	500	380	460	520	480	540	530	650	580
100% Steching strength 100%定伸强度	ISO37	MPa	1.4	1.6	2.2	2.4	2.2	3.5	3.6	5.1	5.2	10.0
Tear Strength 撕裂强度	ISO34-1	KN/m	23	26	29	33	34	45	44	62	70	90
Compression set 压缩变形	ISO815	%	28	30	32	33	35	37	40	58	/	/
Heat Aging Property 热老化性能												
Hardness change 硬度应变	ISO188 1000hrs at 100°C	A	+5	+4	+4	+2	+2	+2	+2	+2	+2	+2
Tensile strength change 拉伸强度应变		%	-18	-16	-18	-12	-8	-8	-6	-8	-10	-13
Elongation@bK 断裂伸长率应变		%	-23	-20	-20	-15	-11	-9	-8	-12	-13	-16
Brittle temperature 脆化温度	ASTMD746	°C	-60	-60	-60	-59	-58	-56	-53	-45	-42	-40
Xenon lamp Property 氙灯老化性能												
Gray scale 灰度级别	PVI303 650h	/	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Appearance 外观		/	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过
Application 应用	/	/	Injections 注塑制品	Injections 注塑制品	Corner window 注塑角窗	Corner window 注塑角窗	Injections 注塑制品	Corner window/ foot pedal 注塑角窗/侧 踏	Injections 注塑制品	Injections 注塑制品	Injections 注塑制品	Injections 注塑制品

Drying Instructions:

干燥说明:

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Suggesting drying as follow process:

干燥工艺建议如下:

Drying conditions 干燥条件	Drying temperature/°C 干燥温度/°C	Drying time/h 干燥时间/时
first choice 首选	80~90	2~3
other choice 备选	100	1

Processing guide 加工参考

rpm 螺杆转速	Zone1 一区	Zone2 二区	Zone3 三区	Zone4 四区	Zone5 五区	Nozzle 喷嘴
40-150	160-190	180-205	190-220	190-235	180-225	170-205

Addition:

附:

Dawnprene TPV is incompatible with PVC materials,hence must clean the equipment before using.

Dawnprene TPV 与 PVC 等材料不相容, 因此使用前必须清理设备.

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Performance data sheet

Type properties 典型性能	Test Method 测试方法	Unit 单位	10-40D	10-45D	10-50D	10-55D	14-35D	14-40D	14-50D
Physical Property 物理性能									
Hardness 硬度	ISO7619	D	42	43	52	57	36	43	52
MFR (230℃, 2.16kg) 熔指	GB/T3682	g/10min	2.0	4.5	6.0	5.0	25	25	18
Density 密度	ISO1183	g/cm ³	0.94	0.88	0.94	0.94	0.92	0.94	1.00
Mechanical Property 力学性能									
Tensile Strength 拉伸强度	ISO37	MPa	18	13.0	16.0	20.0	10.5	15.0	13.0
Elongation@bk 断裂伸长率	ISO37	%	630	750	650	660	600	630	500
100% Steching strength 100%定伸强度	ISO37	MPa	9.0	8.6	12	13.0	7.0	9.5	10.0
Tear Strength 撕裂强度	ISO34-1	KN/m	108	115	120	135	80	110	90
Heat Aging Property 热老化性能									
Hardness change 硬度应变	ISO188 1000hrs at 100℃	D	+2	+2	+2	+2	+2	+2	+2
Tensile strength change 拉伸强度应变		%	-12	-14	-12	-11	-13	-13	-15
Elongation@bK 断裂伸长率应变		%	-15	-18	-16	-17	-16	-15	-20
Brittle temperature 脆化温度	ASTMD746	℃	-38	-38	-36	-32	-40	-38	-35
Xenon lamp Property 氙灯老化性能									
Gray scale 灰度级别	PV1303 650h	/	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Appearance 外观		/	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过	Pass 通过
Application 应用	/		Injections 注塑产品	PAB 安全气囊囊	Injections 注塑产品	Injections 注塑产品	Injections 注塑产品	Fender 注塑产品	Injections 注塑产品

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Suggesting drying as follow process:

干燥工艺建议如下:

Drying conditions 干燥条件	Drying temperature/℃ 干燥温度/℃	Drying time/h 干燥时间/时
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first choice 首选	80~90	2~3
other choice 备选	100	1

Processing guide 加工参考

rpm 螺杆转速	Zone1 一区	Zone2 二区	Zone3 三区	Zone4 四区	Zone5 五区	Nozzle 喷嘴
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