

Dawnprene TPV 811 series

Abstract 概述

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

It is economical series

一种需要提前烘料的 TPV 材料，是经济适用类材料。

Characteristic introduction 特性介绍:

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

材料适用于挤出、注塑、吹塑和其他加工方式，有良好的加工性能，制件表面手感光滑、细腻，兼具高、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 extrusion of automobile sealing strip, building sealing strip, and other extrusion products, injection and blow molding products

此系列材料主要应用于挤出级汽车密封条、建筑密封条，以及其它挤出、注塑和吹塑级产品。

Performance data sheet

Type properties 典型性能	Test Method 测试条件	Unit 单位	811-64A	811-67A	811-67AS	811-73A	811-80A	811-90A	811-45DV
Physical Property 物理性能									
Hardness 硬度	ISO7619-1	A	65	70	70	76	83	93	/
	ISO7619-1	D	/	/	/	/	/	/	47
Density 密度	ISO1183	g/cm3	0.98	0.98	0.97	0.98	0.98	0.95	0.95
Mechanical Property 力学性能									
Tensile Strength 拉伸强度	ISO37	MPa	5.6	6.5	7.0	7.5	8.5	15.0	20.0
Elongation@bk 断裂伸长率	ISO37	%	520	430	520	515	480	680	715
100% Steching strength 100%定伸强度	ISO37	MPa	2.7	3.3	2.6	3.2	3.8	7.6	11.0
Tear Strength 撕裂强度	ISO34-1	KN/m	32	38	40	46	55	105	120
Compression set 压缩变形	ISO815	%	38	40	45	43	47	72	/
Heat Aging Property 热老化性能									
Hardness change 硬度应变	ISO188 1000hrs at 100°C	A	+3	+3	+3	+2	+2	+1	+1
Tensile strength change 拉伸强度应变		%	-22	-20	-21	-18	-20	-14	-12
Elongation@bK 断裂伸长率应变		%	-25	-23	-25	-25	-23	-18	-13
Brittle temperature 脆化温度	ASTMD746	°C	-58	-56	-56	-55	-50	-40	-35
Xenon lamp Property 氙灯老化性能									
Gray scale 亮度	SAE J2527 1250h	/	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		/	Sealing strip 密封条	Belt line 水切密封	Belt line 水切密封	Sealing strip 密封条	Sealing strip 密封条	Sealing strip 密封条	Dust cover 防尘罩

Drying Instructions 干燥说明:

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%.

在加工前需对料粒进行干燥，水分过高会导致材料挤出外观不良、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/°C 干燥温度/°C	Drying time/h 干燥时间/h
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	Die 模具
40-150	160-170	180-185	190-210	190-215	180-205	170-185

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.

回料在使用前必须按上述操作方法执行，并确保无杂质。

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。