

## Dawnprene TPV 11-90AP

### 产品介绍

本材料是热塑性弹性体中的一种，是一种黑色，较软的 TPV 材料。拥有好的物理机械性能，好的耐化学性能及弹性，主要用于挤出，注塑制品。这个牌号的 TPV 可以像热塑性材料加工设备一样进行挤出、注塑，吹塑成型。它是聚烯烃弹性体，可完全回收再利用。

#### Features:

A soft, black thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material combines good physical properties, chemical resistance and elasticity, designed for extrusion, injection and blow molding applications. This grade of TPV can be processed on conventional thermoplastics equipment for injection. It is polyolefin based and completely recyclable.

常规 FEATURES			
应用 Application	* 挤出制品 extrusion		* 注塑制品 injection
RoHS 符合性 RoHS Compliance	* RoHS 符合		
颜色 Color	* 黑色 Black		
形状 Form	* 粒子 Pellet		
成型方法 Molding method	* 挤出 extrusion * 吹塑 injection		
修订时期 Revise date	* 2019-2-27		
物理性能 Physical Properties	典型值 Typical Value	单位 Unit	测试依据 Test Standard
密度 Density	0.959	g/cm <sup>3</sup>	ASTM D792
硬度 Hardness			
邵氏硬度(Shore A, 10 sec, 23°C) (3S 读数) Shore Hardness (Shore A, sec, 23°C)	92	A	ASTM D2240
力学性能 Mechanical Property			
100%定伸强度-垂直流向 23°C Tensile Stress at 100% Elongation-Vertical flow direction 23°C	6.69	Mpa	ASTM D412
拉伸强度-垂直流向 23°C Tensile strength- Vertical flow direction 23°C	16.3	Mpa	ASTM D412
断裂伸长率-垂直流向 23°C Elongation at Break- Vertical flow direction 23°C	650	%	ASTM D412
撕裂强度-垂直流向 23°C Die C Tear strength- Vertical flow direction 23°C Die C	66.2	KN/m	ASTM D624
压缩永久变形 125°C, 22hr Compression set 125°C, 22hr	65.9	%	ASTM D395
压缩永久变形 70°C, 22hr Compression set 70°C, 22hr	49.5	%	ASTM D395
热性能 Thermal properties			
脆化温度 Brittle Temperature	-60	°C	ASTM D746
阻燃性 Flammability			
燃烧速率 Burning Rate	35	mm/min	GB/T8410
老化 Aging properties			
空气中拉伸强度变化(150°C, 94hr) Change in Tensile Strength (150°C, 94hr)	-10.5	%	ASTM D412
空气中断裂伸长率变化(150°C, 94hr)	-14.2	%	

Change in Elongation at Break (150°C, 94hr)			
空气中硬度变化(150°C, 94hr)	-0.5	A	
Change in Shore Hardness(150°C, 94hr)			
耐臭氧老化 (200PPHM, 40°C*72hr)	无裂纹		ASTM D7762
Ozone-resistant aging (200PPHM, 40°C*72hr)	No cracking		
成型方法 Molding Method			

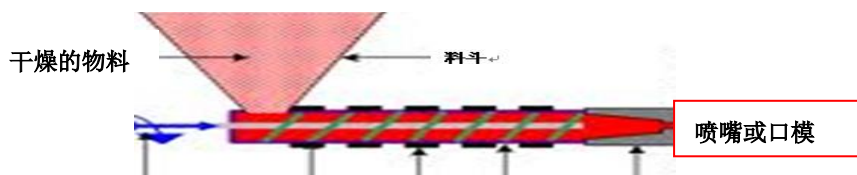
干燥说明：在成型之前需要对粒子进行干燥，水分过大会导致材料外观不良、机械性能下降及制品表面外观差。水分含量要求小于 0.05%，建议如下工艺干燥：

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:

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

在 110°C 以上温度进行干燥，可能会使材料在料筒处结块；若使用水份分析仪，其温度应设定在 105°C，此材料在生产时间较短的情况下，可以不用烘干直接使用，但开口后建议烘干使用。

If drying temperature over than 110°C, it might cause materials blocking in barrel zone; if use moisture analysis meter, the temperature setting should be on 105°C.



螺杆转速 R	一区	二区	三区	四区	五区	喷嘴或口模	模具
40-150	160-170	180-185	190-210	190-210	180-205	170-185	50-70

附加信息

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

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

2. 上述测试数据是采用注塑试片，尺寸为 120 mm × 100 mm × 2 mm, 裁制而成.

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

3. 压缩永久变形的压缩率为 15%。

Compression Set 15%

4. 性能为典型性能，不作为技术指标或协议。

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

5. 回料在使 1 用前必须按上述操作方法执行，并确保无杂质。

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

6. 以上工艺仅供参考，注塑机不同工艺参数也不同，请根据模具与制品形状具体调整

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

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