# Texin® DP7-1049

Thermoplastic Polyurethane Elastomer (Polyether)

Covestro - PUR

## Message:

Texin DP7-1049 resin is an aromatic polyether-based thermoplastic polyurethane with a Shore hardness of approximately 45D. It can be processed by injection molding, extrusion, or blow molding.

| General Information | |
|---|---|
| Features | Impact resistance, good |
| | Good flexibility |
| | Good wear resistance |
| | Hydrolysis resistance |
| | Good toughness |
| | Compliance of Food Exposure |
| | Medium transparency |
| Uses | Cable sheath |
| | Pipe fittings |
| | Seals |
| | Molded Ear Label |
| | Sheet |
| | Footwear |
| | Profile |
| Agency Ratings | FDA 21 CFR 177.1680 |
| | FDA 21 CFR 177.2600 |
| Processing Method | Blow molding |
| | Extrusion |
| | Injection molding |

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Specific Gravity | 1.14 | g/cm³ | ASTM D792, ISO 1183 |
| Molding Shrinkage | | | |
| Flow: 2.54mm | 0.80 | % | ASTM D955 |
| Transverse flow: 2.54mm | 0.80 | % | ASTM D955 |
| Vertical flow direction: 2.54mm | 0.80 | % | ISO 2577 |
| Flow direction: 2.54mm | 0.80 | % | ISO 2577 |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Durometer Hardness (Shore D) | 45 | | ASTM D2240, ISO 868 |

| Mechanical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Flexural Modulus | | | ASTM D790, ISO 178 |
| 23°C | 103 | MPa | ASTM D790, ISO 178 |
| 70°C | 34.5 | MPa | ASTM D790, ISO 178 |
| Taber Abrasion Resistance | | | |
| 1000 Cycles, 1000g, H-18 wheel | 60.0 | mg | ISO 4649 |
| 1000 Cycles, 1000g, H-18 wheel | 60.0 | mg | ASTM D1044 |
| **Elastomers** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Stress | | | |
| 50% strain | 9.70 | MPa | ISO 37, ASTM D412 |
| 100% strain | 11.0 | MPa | ASTM D412, ISO 37 |
| 300% strain | 24.1 | MPa | ASTM D412, ISO 37 |
| Tensile Strength (Yield) | 41.4 | MPa | ASTM D412, ISO 37 |
| Tensile Elongation (Break) | 400 | % | ASTM D412, ISO 37 |
| Tear Strength | | | |
| -- [1] | 127 | kN/m | ASTM D624 |
| -- | 130 | kN/m | ISO 34-1 |
| Compression Set | | | ASTM D395B, ISO 815 |
| 23°C, 22 hr [2] | 20 | % | ASTM D395B, ISO 815 |
| 23°C, 22 hr | 22 | % | ASTM D395B, ISO 815 |
| 70°C, 22 hr [3] | 40 | % | ASTM D395B, ISO 815 |
| 70°C, 22 hr | 75 | % | ASTM D395B, ISO 815 |
| Bayshore Resilience | 35 | % | ASTM D2632 |
| **Aging** | **Nominal Value** | **Unit** | **Test Method** |
| Change in Tensile Strength in Air | | | |
| 100°C, 70 hr | 0.0 | % | ASTM D573, ISO 216 |
| 100% strain, 100°C, 70 hr | 7.0 | % | ASTM D573 |
| 300% strain, 100°C, 70 hr | 5.0 | % | ASTM D573 |
| 100°C, 168 hr | -4.0 | % | ASTM D573, ISO 216 |
| 100% strain, 100°C, 168 hr | 6.0 | % | ASTM D573 |
| 300% strain, 100°C, 168 hr | -1.0 | % | ASTM D573 |
| 100°C, 336 hr | -4.0 | % | ASTM D573, ISO 216 |
| 100% strain, 100°C, 336 hr | 6.0 | % | ASTM D573 |
| 300% strain, 100°C, 336 hr | -1.0 | % | ASTM D573 |
| 100°C, 504 hr | -8.0 | % | ASTM D573, ISO 216 |
| 100% strain, 100°C, 504 hr | 5.0 | % | ASTM D573 |
| 300% strain, 100°C, 504 hr | -3.0 | % | ASTM D573 |
| 100% strain 100°C, 70 hr | 7.0 | % | ISO 216 |
| 300% strain 100°C, 70 hr | 5.0 | % | ISO 216 |
| 100% strain 100°C, 168 hr | 6.0 | % | ISO 216 |
| 300% strain 100°C, 168 hr | -1.0 | % | ISO 216 |
| 100% strain 100°C, 336 hr | 6.0 | % | ISO 216 |

| | | | |
|---|---|---|---|
| 300% strain 100°C, 336 hr | -1.0 | % | ISO 216 |
| 100% strain 100 c, 504 hr | 5.0 | % | ISO 216 |
| 300% strain 100 c, 504 hr | -3.0 | % | ISO 216 |
| Change in Ultimate Elongation in Air | | | ASTM D573, ISO 216 |
| 100°C, 70 hr | 9.0 | % | ASTM D573, ISO 216 |
| 100°C, 168 hr | 14 | % | ASTM D573, ISO 216 |
| 100°C, 336 hr | 13 | % | ASTM D573, ISO 216 |
| 100°C, 504 hr | 17 | % | ASTM D573, ISO 216 |
| Change in Durometer Hardness in Air | | | ASTM D573, ISO 216 |
| Support d, 100°C, 70 hr | -1.0 | | ASTM D573, ISO 216 |
| Support d, 100°C, 168 hr | 0.0 | | ASTM D573, ISO 216 |
| Support d, 100 c, 336 hr | -1.0 | | ASTM D573, ISO 216 |
| Support d, 100 c, 504 hr | 0.0 | | ASTM D573, ISO 216 |
| Change in Tensile Strength | | | |
| 23°C, 70 hr, Class C Standard Fuel | -25 | % | ASTM D471 |
| 100% strain, 23°C, 70 hr, Class C standard fuel | -32 | % | ASTM D471 |
| 300% strain, 23°C, 70 hr, Class C standard fuel | -33 | % | ASTM D471 |
| 23°C, 70 hr, in reference fuel A | 10 | % | ASTM D471 |
| 100% strain, 23°C, 70 hr, in reference fuel A | -2.0 | % | ASTM D471 |
| 300% strain, 23°C, 70 hr, in reference fuel A | -3.0 | % | ASTM D471 |
| 23°C, 168 hr, Class C Standard Fuel | -26 | % | ASTM D471 |
| 100% strain, 23°C, 168 hr, Class C standard fuel | -28 | % | ASTM D471 |
| 300% strain, 23°C, 168 hr, Class C standard fuel | -30 | % | ASTM D471 |
| 23°C, 168 hr, in reference fuel A | 4.0 | % | ASTM D471 |
| 100% strain, 23°C, 168 hr, in reference fuel a | 8.0 | % | ASTM D471 |
| 300% strain, 23°C, 168 hr, in reference fuel a | 0.0 | % | ASTM D471 |
| 23°C, 336 hr, Class C Standard Fuel | -28 | % | ASTM D471 |
| 100% strain, 23°C, 336 hr, Class C standard fuel | -27 | % | ASTM D471 |
| 300% strain, 23°C, 336 hr, Class C standard fuel | -30 | % | ASTM D471 |
| 23°C, 336 hr, in reference fuel A | 8.0 | % | ASTM D471 |
| 100% strain, 23°C, 336 hr, in reference fuel A | 1.0 | % | ASTM D471 |
| 300% strain, 23°C, 336 hr, in reference fuel A | -5.0 | % | ASTM D471 |
| 23°C, 504 hr, Class C Standard Fuel | -24 | % | ASTM D471 |

| | | | |
|---|---|---|---|
| 100% strain, 23°C, 504 hr, Class C standard fuel | -27 | % | ASTM D471 |
| 300% strain, 23°C, 504 hr, Class C standard fuel | -28 | % | ASTM D471 |
| 23°C, 504 hr, in reference fuel A | 7.0 | % | ASTM D471 |
| 100% strain, 23°C, 504 hr, in reference fuel A | -4.0 | % | ASTM D471 |
| 300% strain, 23°C, 504 hr, in reference fuel A | -8.0 | % | ASTM D471 |
| 100°C, 70 hr, in ASTM #1 oil | -4.0 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 70 hr, in ASTM #1 oil | 10 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 70 hr, in ASTM #1 oil | 8.0 | % | ASTM D471, ISO 175 |
| 100°C, 70 hr, in ASTM #3 oil | 10 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 70 hr, in ASTM #3 oil | 2.0 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 70 hr, in ASTM #3 oil | -1.0 | % | ASTM D471, ISO 175 |
| 100°C, 168 hr, in ASTM #1 oil | -11 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 168 hr, in ASTM #1 oil | 4.0 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 168 hr, in ASTM #1 oil | -4.0 | % | ASTM D471, ISO 175 |
| 100°C, 168 hr, in ASTM #3 oil | 9.0 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 168 hr, in ASTM #3 oil | -7.0 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 168 hr, in ASTM #3 oil | -10 | % | ASTM D471, ISO 175 |
| 100°C, 336 hr, in ASTM #1 oil | -11 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 336 hr, in ASTM #1 oil | 11 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 336 hr, in ASTM #1 oil | 0.0 | % | ASTM D471, ISO 175 |
| 100°C, 336 hr, in ASTM #3 oil | 7.0 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 336 hr, in ASTM #3 oil | 2.0 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 336 hr, in ASTM #3 oil | -7.0 | % | ASTM D471, ISO 175 |
| 100°C, 504 hr, in ASTM #1 oil | -14 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 504 hr, in ASTM #1 oil | 5.0 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 504 hr, in ASTM #1 oil | -9.0 | % | ASTM D471, ISO 175 |
| 100°C, 504 hr, in ASTM #3 oil | -9.0 | % | ASTM D471, ISO 175 |
| 100% strain, 100°C, 504 hr, in ASTM #3 oil | -4.0 | % | ASTM D471, ISO 175 |
| 300% strain, 100°C, 504 hr, in ASTM #3 oil | -15 | % | ASTM D471, ISO 175 |
| 23°C, 70 hr, in Reference Fuel C | -25 | % | ISO 175 |
| 100% strain, 23 c, 70 hr, in Reference Fuel C | -32 | % | ISO 175 |

| | | | |
|---|---|---|---|
| 300% strain, 23 c, 70 hr, in Reference Fuel C | -33 | % | ISO 175 |
| 23°C, 70 hr, in reference fuel A (isooctane) | 10 | % | ISO 175 |
| 100% strain, 23°C, 70 hr, in reference fuel A (isooctane) | -2.0 | % | ISO 175 |
| 300% strain, 23°C, 70 hr, in reference fuel A (isooctane) | -3.0 | % | ISO 175 |
| 23°C, 168 hr, in Reference Fuel C | -26 | % | ISO 175 |
| 100% strain, 23 c, 168 hr, in Reference Fuel C | -28 | % | ISO 175 |
| 300% strain, 23 c, 168 hr, in Reference Fuel C | -30 | % | ISO 175 |
| 23°C, 168 hr, in reference fuel A (isooctane) | 4.0 | % | ISO 175 |
| 100% strain, 23°C, 168 hr, in reference fuel A (isooctane) | 8.0 | % | ISO 175 |
| 300% strain, 23°C, 168 hr, in reference fuel A (isooctane) | 0.0 | % | ISO 175 |
| 23°C, 336 hr, in Reference Fuel C | -28 | % | ISO 175 |
| 100% strain, 23 c, 336 hr, in Reference Fuel C | -27 | % | ISO 175 |
| 300% strain, 23 c, 336 hr, in Reference Fuel C | -30 | % | ISO 175 |
| 23°C, 336 hr, in reference fuel A (isooctane) | 8.0 | % | ISO 175 |
| 100% strain, 23°C, 336 hr, in reference fuel A (isooctane) | 1.0 | % | ISO 175 |
| 300% strain, 23°C, 336 hr, in reference fuel A (isooctane) | -5.0 | % | ISO 175 |
| 23°C, 504 hr, in Reference Fuel C | -24 | % | ISO 175 |
| 100% strain, 23 c, 504 hr, in Reference Fuel C | -27 | % | ISO 175 |
| 300% strain, 23 c, 504 hr, in Reference Fuel C | -28 | % | ISO 175 |
| 23°C, 504 hr, in reference fuel A (isooctane) | 7.0 | % | ISO 175 |
| 100% strain, 23°C, 504 hr, in reference fuel A (isooctane) | -4.0 | % | ISO 175 |
| 300% strain, 23°C, 504 hr, in reference fuel A (isooctane) | -8.0 | % | ISO 175 |
| Change in Ultimate Elongation | | | |
| 23°C, 70 hr, Class C Standard Fuel | -5.0 | % | ASTM D471 |
| 23°C, 70 hr, in reference fuel A | 5.0 | % | ASTM D471 |
| 23°C, 168 hr, Class C Standard Fuel | -4.0 | % | ASTM D471 |
| 23°C, 168 hr, in reference fuel A | 1.0 | % | ASTM D471 |
| 23°C, 336 hr, Class C Standard Fuel | -6.0 | % | ASTM D471 |
| 23°C, 336 hr, in reference fuel A | 4.0 | % | ASTM D471 |

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|---|---|---|---|
| 23°C, 504 hr, Class C Standard Fuel | -6.0 | % | ASTM D471 |
| 23°C, 504 hr, in reference fuel A | 6.0 | % | ASTM D471 |
| 100°C, 70 hr, in ASTM #1 oil | 11 | % | ASTM D471, ISO 175 |
| 100°C, 70 hr, in ASTM #3 oil | 19 | % | ASTM D471, ISO 175 |
| 100°C, 168 hr, in ASTM #1 oil | 21 | % | ASTM D471, ISO 175 |
| 100°C, 168 hr, in ASTM #3 oil | 32 | % | ASTM D471, ISO 175 |
| 100°C, 336 hr, in ASTM #1 oil | 20 | % | ASTM D471, ISO 175 |
| 100°C, 336 hr, in ASTM #3 oil | 25 | % | ASTM D471, ISO 175 |
| 100°C, 504 hr, in ASTM #1 oil | 24 | % | ASTM D471, ISO 175 |
| 100°C, 504 hr, in ASTM #3 oil | 30 | % | ASTM D471, ISO 175 |
| 23°C, 70 hr, in Reference Fuel C | -5.0 | % | ISO 175 |
| 23°C, 70 hr, in reference fuel A (isooctane) | 5.0 | % | ISO 175 |
| 23°C, 168 hr, in Reference Fuel C | -4.0 | % | ISO 175 |
| 23°C, 168 hr, in reference fuel A (isooctane) | 1.0 | % | ISO 175 |
| 23°C, 336 hr, in Reference Fuel C | -6.0 | % | ISO 175 |
| 23°C, 336 hr, in reference fuel A (isooctane) | 4.0 | % | ISO 175 |
| 23°C, 504 hr, in Reference Fuel C | -6.0 | % | ISO 175 |
| 23°C, 504 hr, in reference fuel A (isooctane) | 6.0 | % | ISO 175 |
| Change in Durometer Hardness | | | |
| Support D, 23°C, 70 hr, in Reference Fuel C | -6.0 | | ASTM D471, ISO 175 |
| Support D, 23°C, 70 hr, in reference fuel A | -1.0 | | ASTM D471 |
| Support D, 23°C, 168 hr, in Reference Fuel C | -5.0 | | ASTM D471, ISO 175 |
| Support D, 23°C, 168 hr, in reference fuel A | -1.0 | | ASTM D471 |
| Support d, 23 c, 336 hr, in Reference fuel c | -7.0 | | ASTM D471, ISO 175 |
| Support D, 23°C, 336 hr, in reference fuel A | 0.0 | | ASTM D471 |
| Support D, 23°C, 504 hr, in Reference Fuel C | -6.0 | | ASTM D471, ISO 175 |
| Support D, 23°C, 504 hr, in reference fuel A | -1.0 | | ASTM D471 |
| Support D, 100°C, 70 hr, in ASTM #1 oil | -1.0 | | ASTM D471 |
| Support D, 100°C, 70 hr, in ASTM #3 oil | -4.0 | | ASTM D471 |
| Support D, 100°C, 168 hr, in ASTM #1 oil | 2.0 | | ASTM D471 |
| Support D, 100°C, 168 hr, in ASTM #3 oil | -4.0 | | ASTM D471 |
| Support D, 100°C, 336 hr, in ASTM #1 oil | -1.0 | | ASTM D471 |
| Support D, 100°C, 336 hr, in ASTM #3 oil | -4.0 | | ASTM D471 |
| Support D, 100°C, 504 hr, in ASTM #1 oil | 0.0 | | ASTM D471 |

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|---|---|---|---|
| Support D, 100°C, 504 hr, in ASTM #3 oil | -4.0 | | ASTM D471 |
| Support D, 23°C, 70 hr, in reference fuel A (isooctane) | -1.0 | | ISO 175 |
| Support D, 23°C, 168 hr, in reference fuel A (isooctane) | -1.0 | | ISO 175 |
| Support D, 23°C, 336 hr, in reference fuel A (isooctane) | 0.0 | | ISO 175 |
| Support D, 23°C, 504 hr, in reference fuel A (isooctane) | -1.0 | | ISO 175 |
| Support D, 100°C, 70 hr, in ASTM #1 oil | -1.0 | | ISO 175 |
| Support D, 100°C, 70 hr, in ASTM #3 oil | -4.0 | | ISO 175 |
| Support D, 100°C, 168 hr, in ASTM #1 oil | 2.0 | | ISO 175 |
| Support D, 100°C, 168 hr, in ASTM #3 oil | -4.0 | | ISO 175 |
| Support D, 100°C, 336 hr, in ASTM #1 oil | -1.0 | | ISO 175 |
| Support D, 100°C, 336 hr, in ASTM #3 oil | -4.0 | | ISO 175 |
| Support D, 100°C, 504 hr, in ASTM #1 oil | 0.0 | | ISO 175 |
| Support D, 100°C, 504 hr, in ASTM #3 oil | -4.0 | | ISO 175 |
| Change in Volume | | | |
| 23°C, 70 hr, Class A standard fuel | 1.0 | % | ASTM D471 |
| 23°C, 70 hr, Class C Standard Fuel | 30 | % | ASTM D471 |
| 23°C, 168 hr, Class A standard fuel | 2.0 | % | ASTM D471 |
| 23°C, 168 hr, Class C Standard Fuel | 32 | % | ASTM D471 |
| 23°C, 336 hr, Class A standard fuel | 3.0 | % | ASTM D471 |
| 23°C, 336 hr, Class C Standard Fuel | 33 | % | ASTM D471 |
| 23°C, 504 hr, Class A standard fuel | 3.0 | % | ASTM D471 |
| 23°C, 504 hr, Class C Standard Fuel | 31 | % | ASTM D471 |
| 100°C, 70 hr, ASTM Standard Oil (No.1) | 1.0 | % | ASTM D471 |
| 100°C, 70 hr, ASTM Standard Oil (No.3) | 12 | % | ASTM D471 |
| 100°C, 168 hr, ASTM Standard Oil (No.1) | -1.0 | % | ASTM D471 |
| 100°C, 168 hr, ASTM Standard Oil (No.3) | 13 | % | ASTM D471 |
| 100°C, 336 hr, ASTM Standard Oil (No.1) | 0.0 | % | ASTM D471 |
| 100°C, 336 hr, ASTM Standard Oil (No.3) | 17 | % | ASTM D471 |
| 100°C, 504 hr, ASTM Standard Oil (No.1) | 0.0 | % | ASTM D471 |
| 100°C, 504 hr, ASTM Standard Oil (No.3) | 16 | % | ASTM D471 |
| 23°C, 70 hr, in reference fuel A | 1.0 | % | ISO 175 |
| 23°C, 70 hr, in reference fuel C | 30 | % | ISO 175 |
| 23°C, 168 hr, in reference fuel A | 2.0 | % | ISO 175 |
| 23°C, 168 hr, in reference fuel C | 32 | % | ISO 175 |
| 23°C, 336 hr, in reference fuel A | 3.0 | % | ISO 175 |
| 23°C, 336 hr, in reference fuel C | 33 | % | ISO 175 |
| 23°C, 504 hr, in reference fuel A | 3.0 | % | ISO 175 |
| 23°C, 504 hr, in reference fuel C | 31 | % | ISO 175 |
| 100°C, 70 hr, in ASTM #1 oil | 1.0 | % | ISO 175 |

| | | | |
|---|---|---|---|
| 100°C, 70 hr, in ASTM #3 oil | 12 | % | ISO 175 |
| 100°C, 168 hr, in ASTM #1 oil | -1.0 | % | ISO 175 |
| 100°C, 168 hr, in ASTM #3 oil | 13 | % | ISO 175 |
| 100°C, 336 hr, in ASTM #1 oil | 0.0 | % | ISO 175 |
| 100°C, 336 hr, in ASTM #3 oil | 17 | % | ISO 175 |
| 100°C, 504 hr, in ASTM #1 oil | 0.0 | % | ISO 175 |
| 100°C, 504 hr, in ASTM #3 oil | 16 | % | ISO 175 |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Brittleness Temperature | < -68.0 | °C | ASTM D746, ISO 974 |
| Glass Transition Temperature | -40.0 | °C | DMA |
| Vicat Softening Temperature | 116 | °C | ISO 306/50, ASTM D1525 [4] |
| **Additional Information** | **Nominal Value** | **Unit** | **Test Method** |
| Compressive Load | | | ASTM D575 |
| 10% Deflection | 3.79 | MPa | ASTM D575 |
| 15% Deflection | 5.34 | MPa | ASTM D575 |
| 2% Deflection | 0.896 | MPa | ASTM D575 |
| 20% Deflection | 6.89 | MPa | ASTM D575 |
| 25% Deflection | 8.38 | MPa | ASTM D575 |
| 5% Deflection | 2.10 | MPa | ASTM D575 |
| 50% Deflection | 21.5 | MPa | ASTM D575 |
| **Injection** | **Nominal Value** | **Unit** | |
| Drying Temperature - Desiccant Dryer | 99.0 - 110 | °C | |
| Drying Time - Desiccant Dryer | 2.0 | hr | |
| Suggested Max Moisture | < 0.030 | % | |
| Suggested Shot Size | 40 - 80 | % | |
| Suggested Max Regrind | 20 | % | |
| Rear Temperature | 182 - 199 | °C | |
| Middle Temperature | 182 - 204 | °C | |
| Front Temperature | 182 - 210 | °C | |
| Nozzle Temperature | 188 - 213 | °C | |
| Processing (Melt) Temp | 196 - 207 | °C | |
| Mold Temperature | 16.0 - 38.0 | °C | |
| Injection Pressure | 41.4 - 103 | MPa | |
| Injection Rate | Slow-Moderate | | |
| Back Pressure | < 1.38 | MPa | |
| Screw Speed | 40 - 80 | rpm | |
| Clamp Tonnage | 4.1 - 6.9 | $kN/cm^2$ | |
| Cushion | < 3.18 | mm | |
| Screw L/D Ratio | 20.0:1.0 | | |
| Screw Compression Ratio | 2.5:1.0 - 3.0:1.0 | | |
| **Injection instructions** | | | |

Hold Pressure: 60 to 80% of Injection PressureTimers (per 0.125 in cross section):
Boost: 5 to 10 sec
2nd Stage: 10 to 30 sec
Cool: 30 to 50 sec

| Extrusion | Nominal Value | Unit |
|---|---|---|
| Drying Temperature | 99.0 - 110 | °C |
| Drying Time | 2.0 | hr |
| Cylinder Zone 1 Temp. | 182 - 199 | °C |
| Cylinder Zone 2 Temp. | 182 - 204 | °C |
| Cylinder Zone 3 Temp. | 182 - 210 | °C |
| Adapter Temperature | 182 - 210 | °C |
| Melt Temperature | 191 - 204 | °C |
| Die Temperature | 188 - 210 | °C |

| NOTE | |
|---|---|
| 1. | C mould |
| 2. | Post-cured 16 hr at 230°F |
| 3. | Post-cured 16 hr at 230°F |
| 4. | 速率 A (50°C/h) |



## Recommended distributors for this material

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WECHAT