

## 1WLG585D8 中硬度

### TPU 40%長 GF、韌性、超高剛性、耐熱強化塑料

#### DATA SHEET

Product : 1WLG585D8

射出級 injection

#### Description

**1WLG585D8** 高性能工程 TPU 複合材料，含 40% 的長玻璃纖維複合，它具備有優異之韌性、高機械強度、耐磨耗性以及耐溶劑性，可抗 UV 在紫外線照射下保持良好的物理性能，適用於射出用途。

1WLG585D8 high-performance engineering TPU composite material, containing 40% long glass fiber composite, it has excellent toughness, high mechanical strength, wear-resistance and solvent resistance can resist UV to maintain good physical properties under ultraviolet irradiation, Suitable for injection purposes.

#### 特性 Properties

| Properties   | Test Method | Typical Values |
|--|-------------|----------------|
| 硬度 Shore D Hardness  | ASTM D-2240 | 85             |
| 比重 Specific Gravity g/cm <sup>3</sup>                                | ASTM D-792  | 1.5            |
| % Long Glass Fiber   |             | 40             |
| 物理性質 Physical Properties   |             |                |
| 拉伸降伏強度 Tensile Strength Yield kg/cm <sup>2</sup>                     |             | 1930           |
| 拉伸斷裂強度 Tensile Strength break kg/cm <sup>2</sup>                     | ASTM D-638  | 1730           |
| 斷裂伸長率 Elongation at Break %  |             | 2              |
| 彎曲強度 Flexural Strength kg/cm <sup>2</sup>                            | ASTM D790   | 2440           |
| 彎曲彈性係數 Flexural Modulus kg/cm <sup>2</sup>                           |             | 101800         |
| 衝擊強度(缺口式)IZOD Impact (notched) 23°C (1/8" ) kg-cm/cm                 | ASTM D256   | 29             |
| 熱力特性 Heat properties   |             |                |
| 熱變形溫度 4.68kg/ cm <sup>2</sup> (H D T) Heat Deflection Temperature °C | ASTM D256   | 96             |
| 熱變形溫度 18.6kg/ cm <sup>2</sup> (H D T) Heat Deflection Temperature °C |             | 90             |
| 維氏軟化點 Vicat Softening Point °C                                       | ASTM D1525  | 180            |
| 其他屬性 Miscellaneous Properties  |             |                |
| 燃燒性 Flammability UL94  |             | HB             |

\*以上數據僅供參考 The above data are for reference only\*

TPU 1WLG585D8 TDS 1/2

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**射出成型條件 Injection molding conditions**

建議乾燥溫度 Recommended drying temperature: 110~130°C

建議乾燥時間 Recommended drying time: 4H

TPU 樹脂具有吸濕性，TPU 樹脂的預乾燥始終是加工前的必要步驟。依氣候，暴露在大氣中的顆粒會很快吸收水分。水分可能會導致聚合物的部分降解以及在模製和擠出部件中形成氣泡或條紋。為了確保高效和成功加工成優質部件，請參考建議烘乾溫度及時間。

TPU resin has hygroscopicity, and pre-drying of TPU resin is always a necessary step before processing. Relying on the climate, particles exposed to the atmosphere will quickly absorb moisture. Moisture may cause partial degradation of the polymer and formation of air bubbles or streaks in molded and extruded parts. In order to ensure efficient and successful processing into high quality parts, please refer to the recommended drying temperature and time.

**建議射出成型溫度：**

| 硬度  | Zone1   | Zone2   | Zone3   | 噴嘴部     | 射出壓力    | 冷卻溫度  |
|-----|---------|---------|---------|---------|---------|-------|
| 85D | 200~210 | 220~230 | 230~245 | 240~250 | 300~660 | 20~35 |

成型溫度以低標為設定基準試做，逐步以 5°C 升高成型溫度，直到適合成型溫度即可，否則溫度過高，產品容易產生變色、過火熱烈解。

The molding temperature is tested by setting the low standard as a reference, and gradually increasing the molding temperature by 5°C until it is suitable for the molding temperature. Otherwise, the temperature is too high, and the product is prone to discoloration and overheating.

**供應與儲存 Supply and Storage**

TPU 樹脂以顆粒形式提供，包裝在 25kg 防潮袋中。所有 TPU 樹脂在包裝前都已經乾燥。TPU 樹脂應儲存在陰涼乾燥的環境中，直到使用前為止。儲存溫度不應超過 30°C。如果僅從袋中使用一部分 TPU 樹脂，則其餘 TPU 樹脂應該緊密封閉。

TPU resins are supplied in pellet form packed in 25kg moisture proof bags. All TPU resins have been dried before packing. Isothane TPU resins should be stored in cool and dry environment in their original containers until be used. Storage temperature should not exceed 30°C. If only a portion of TPU resins was used from a bag, the remainder of TPU resins should be tightly closed.

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