

## TPU “BURBUJA” TECHNICAL DATA SHEET

### Product Feature:

**TPU BURBUJA** is an ester based thermoplastic polyurethane elastomer (TPU) with good transparency, good mechanical properties, good heat resistance, humidity resistance, and excellent flexibility under very low temperature. It is injection blowing molding grade for air cushions.

### Product Properties:

Typical Properties	Test Method	Units	Typical values*
Form	N/A	-	Granules
Color	N/A	-	Transparent
Hardness	ASTM D-2240	shore A	90
100% Modulus of elasticity	ASTM D412	MPa	12
Tensile Stress	ASTM D-412	MPa	35
Tear Strength	ASTM D-624	N/mm	120
Ultimate Elongation	ASTM D-412	%	550
Yellow degree	ASTM E-313	---	1
Haze(2mm)	ASTM D-1003	%	2

\*Above data for reference only.

**Processing Guidelines:**

**Injection Moulding Guidelines**

Mold Shrinkage: 0.015 ~ 0.025 inch/inch

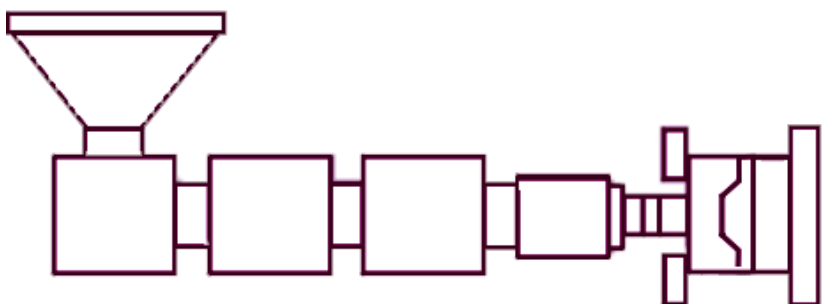
Injection Speed: Medium - Fast

Injection Pressure: Medium - Fast

Back Pressure: Low - Medium

Holding Pressure: Sufficient to pack the mould

Cooling: Can be demoulded when parts have sufficiently cooled



Barrel Temperature (°C)

150-170      170-190      180-200      200-215      25-45

**Extrusion Guidelines**

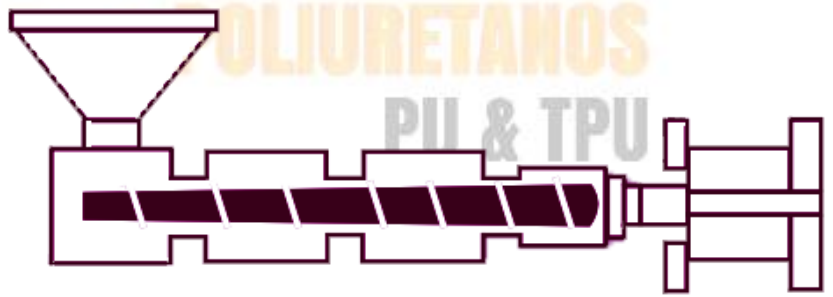
L/D Ratio: 20:1 - 25:1

Compression Ratio: 2.5 - 3.0

Breaker Plate/Screen: Both should be used

Draw Down: 5 - 10%

Cooling: Cold water bath



Barrel Temperature (°C)

150-170      200-210      210-230      200-235      180-200

**Processing Notes:**

- A、 Drying before processing, it is recommended to dry for 3-5 hours at 90 degrees centigrade. If it is damp, the drying time will be lengthened.
- B、 Cleaning the screw and die with PP or PE before and after processing.
- C、 The gate and runner can be recycled, but less than 15%.
- D、 PE/EVA base color masterbatch is better for coloring.



The information and suggestions contained in this bulletin are to the best of our knowledge, accurate and reliable, but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchasers assume all risks and liability for the results of use of the products, including use in accordance with seller's suggestions. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or by others. There is no warranty of merchantability and there are no other warranties for the products described.

