

Technical Data Sheet

Product Feature:

GURAM® is TPE compounding produced by KESUN. It's safe, recyclable and environmentally friendly with soft touch and good elasticity and also excellent pigmentation, as well as good weather resistance. It is used in injection, extrusion, calendaring and blow molding with good processing stability. It has wide applications in daily necessities, sports accessories, toys, decorative materials, auto parts and other applications.

Solex6185 is TPE compounding based on Styrene Butadiene Copolymer, it's no odor, has soft touch, smooth surface and excellent elasticity, Specifications for injection molding developed for high-end products.

Product Properties:

Typical Properties	Test Method	Units	Typical values*
Form	N/A	-	Particle
Color	N/A	-	Natural
Hardness	ASTM D-2240	shore A	85
Specific Gravity	ASTM D-792	g/cm ³	1.03
Tensile Stress	ASTM D-412	MPa	6
Tear Strength	ASTM D-624	N/mm	35
Ultimate Elongation	ASTM D-412	%	350
DIN Abrasion	ASTM D-5963	mm ³	<250

*Above data for reference only.

Kunshan Kesun Polymer Co., Ltd

Add: No 108 Jinmao Road, Zhoushi Town, Kunshan City, Jingshu, China

Tel: 0512-55173009

Web: www.kesuntpe.com

PC: 215300

Fax: 0512-57784279

E-mail: info@kesuntpe.com

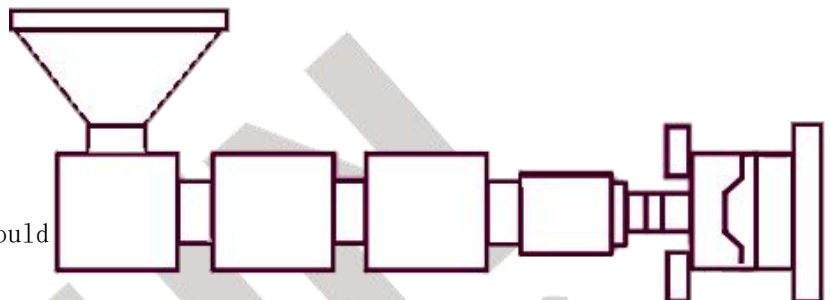
Processing Guidelines:

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)

130-170 150-190 160-200 160-200 15-50

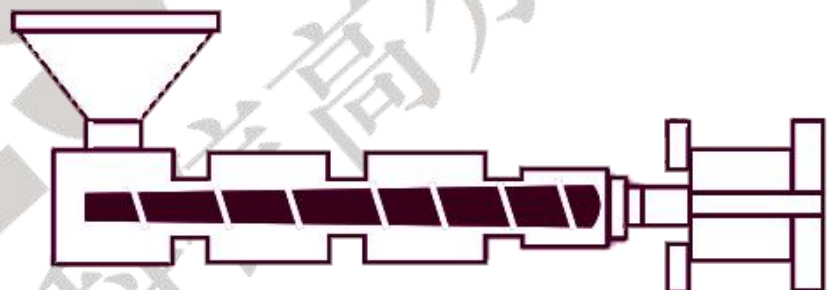


Extrusion Guidelines

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)

150-170 170-200 180-210 180-210 180-210



Processing Notes:

- Normally need not drying, if absorbed moisture, pre-drying the particles for 2 to 4 hours at 80°C.
- Cleaning the screw and die with PP or PE before and after processing.
- The gate and runner can be recycled, but less than 15%.
- PE/EVA base color masterbatch is better for coloring.

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