

**DW Series**
**THERMOLAST® K**

**The DW Series is your material solution for applications in contact with drinking water. The compounds are approved in accordance with all relevant European drinking water standards – DVGW, W270, KTW, WRAS, ACS.**

**Typical applications**

- Seals, functional and designelements in sanitary sector
- Shower heads

**Material advantages**

- Adhesion to PP/PE
- Easy coloring
- For injection molding and extrusion
- Smooth surface and repels dirt and lime deposit
- Thermoplastic alternative material to elastomers

**Processing Method:** Extrusion, Injection Molding

	Color	Hardness Shore A DIN ISO 7619 ShoreA	Density DIN EN ISO 1183-1 g/cm <sup>3</sup>	Tensile Strength <sup>1</sup> DIN 53504/ISO 37 MPa	Elong. at Break S2 <sup>1</sup> DIN 53504 / ISO 37 %	Tear Resistance DIN ISO 34-1 N/mm
<b>TF5WKF</b>	natural	53	0.890	10.0	800	15.0
<b>TF6WKF</b>	natural	62	0.890	12.5	850	20.0
<b>TF7WKF</b>	natural	72	0.890	13.0	800	35.0
<b>TF8WKF</b>	natural	83	0.890	16.0	800	39.0
<b>TF9WKF</b>	natural	86	0.890	16.0	800	39.0

<sup>1</sup> Deviating from ISO 37 standard test piece S2 is tested with a traverse speed of 200 mm/min.

- WRAS (BS 6920) for cold- and warm water applications in natural color and colored - W270 in natural color and colored - Compliance regarding ACS DGS/VS4 2000/232 dated 27.4.2000, DGS/VS4 n° 99/217 dated 04/12/1999 - KTW guideline for 23 °C and 60 °C (or transition regulation of UBA from 04/21/2012 for cold water 73 °F (23 °C) and warm water 140 °F (60 °C))

All values published in this data sheet are rounded average values.  
Specification limits are based on three-fold standard deviation from the average value.

This datasheet is an extract of the KRAIBURG TPE program. Please contact KRAIBURG TPE to select the compound suitable for the requirements.

Disclaimer: The information provided in this documentation corresponds to our knowledge on the subject at the date of its publication and may be subject to revision as new knowledge and data becomes available. All values reported are typical values based on sample test results and are not a guarantee of performance. The responsibility to conduct testing to determine suitability of use for the particular process or end-use application remains with the customer. KRAIBURG TPE does not warrant or assume any liability with regards to the use of the information presented in this document.

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**Processing Guideline Extrusion**

Cylinder temperature	160 - 180 - 200 °C; max. 230 °C (320 - 356 - 392 °F; max. 446 °F).
L/D ratio	At least 25
Compression ratio	At least 3.5 : 1
Screens / breaker plate	A breaker plate and a screen pack are generally recommended in the extruder configuration in order to increase pressure.
Die land	3 - 5 mm (0,12 - 0,16 in.)
Extruder Head	Ca. 180 °C (355 °F)
Die temperature	Ca. 190 - 180 °C (374 - 410 °F)
Screw geometry	Standard three-zone screw (e.g. polyolefin screw). The screw must be able to provide sufficient shearing.
Calibration	Generally not necessary; support elements may be required when extruding THERMOLAST® compounds with high hardness or when coextruding with standard thermoplastics.
Pre drying	Pre drying of the material is not necessary; if surface moisture forms as a result of changes in temperature, the material should be dried for 2 - 4 hours at 60 - 80 °C (140 - 175 °F).

**Processing Guideline Injection Molding**

Cylinder temperature	200 - 190 - 180 °C, max. 225 °C (390 - 374 - 356 °F, max. 437 °F)
Hotrunner	Hot runner temperatures: 200 -250 °C (390 - 480 °F). The runner should be empty after a maximum of 2 - 3 shots.
Injection pressure	200 - 1000 bar (2900 - 14504 psi) (depending on the size and weight of the part).
Injection rate	In general, the fill time should not be more than 1–2 seconds.

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**Processing Guideline Injection Molding**

Hold pressure	We recommend to derive the optimum hold pressure from determining the solidification point, starting with 40 % - 60 % of the required injection pressure.
Back pressure	20 - 50 bar (285 - 710 psi); if colour batches are used, higher back pressure is necessary.
Screw retraction	If an open nozzle is used processing with screw retraction is advisable.
Mold temperature	25 - 40 °C (77 - 104 °F)
Pre drying	Pre drying of the material is not necessary; if surface moisture forms as a result of changes in temperature, the material should be dried for 2 - 4 hours at 60°C (140° F).
Needle shut-off	With materials < 50 Shore the use of a needle seal nozzle is advisable.
Screw geometry	Standard 3-zone polyolefine screw.
Cleaning recommendation	For cleaning and purging of the machine it is appropriate to use polypropylene or polyethylene. Machine must be PVC-free.

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