

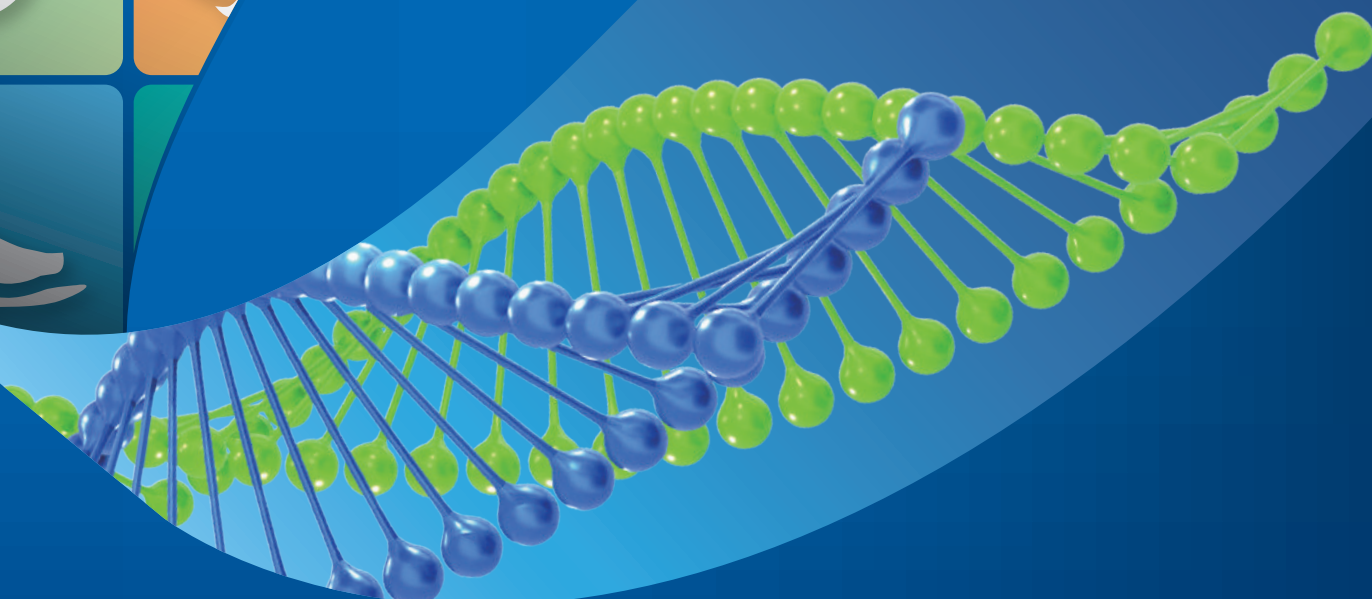
KINJOIN

崑仲集團

**KALLOY<sup>®</sup> TPE**

**TPE**

Professional Manufacturing Factory



KIN JOIN

[www.tpu.tw](http://www.tpu.tw)



**KALLOY® TPE**

#### KIN JOIN

- 2001年成立福州廠
- 2004年設立東莞廠
- 2010年建立泉州廠
- Fuzhou factory was established in 2001
- Dongguan factory was established in 2004
- Quanzhou factory was established in 2010

## 歷史沿革

崑仲股份有限公司(臺灣)創立於 1993年，以生產熱可塑性彈性體為主之專業廠商，產品均為綠色環保材料。主要生產 TPU,TPR,TPV,TPE等熱可塑性彈性體，產品行銷世界各地，品質及服務深受廣大客戶讚譽。

本公司創立以來一直秉持『精益求精、服務至上、永續發展』為經營理念，在品質管理、生產安全、社會環保方面建立了一套合乎國際品質保證之標準。同時，我們不斷地追求技術創新，擁有高素質的研發團隊，精密的分析儀器，使我們保持市場之競爭優勢。

公司本著對保護自然環境負責態度，開發出 PULLON® TPU 與 KOSLEN® TPU, KALLOY® TPE和多元醇系列環保產品，以新概念、多功能的材質滿足不同之客戶需求。

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## History

Established in 1993, KINJOIN CO., LTD. (Taiwan) is a professional manufacturer of thermoplastic elastomers which are green and environmentally friendly products. We mainly produce thermoplastic elastomers such as TPU, TPR, and TPE sold all over the world with outstanding quality and considerate service among customers.

Since the establishment, the company has been upholding the business philosophy of “pursuing excellence, service-oriented and sustainable development” and setting up a set of standards in line with international quality assurance in quality management, production safety and social and environmental protection. Meanwhile, we continue to pursue the technical innovation, own a smart R & D team and have high-tech analytical instruments. Therefore we have the advantages and features to keep market competitiveness in various applications.

With the responsible attitude towards natural environmental protection, our company has developed PULLON® TPU and KOSLEN® TPU, KALLOY® TPE and series polyols that are environmentally friendly products to meet the needs of different customers by new concept and multi-functional materials.



## TPE

Profession Manufacturing Factory



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KIN JOIN



**KALLOY® TPE**



# KALLOY® TPE

## 熱可塑性彈性體

Thermoplastic elastomer

TPE具有橡膠的彈性、優良的物性、耐寒性、電絕緣性，同時可採用一般塑膠機械、模具成型。適用於射出、押出、吹膜及壓延加工等。與傳統橡膠相比，省去了硫化程序，具有加工簡單、成型週期短、生產效率高、邊角料可回收、用料經濟、產品質量穩定、比重輕等優點。

TPE has rubber elasticity, excellent physical properties, cold resistance and electrical insulation, and can be molded by general plastic machinery and mold. Suitable for injection, extrusion, blown film and calendaring. Compared with traditional rubber, the sulfurization process is omitted, which has the advantages of simple processing, short molding cycle, high production efficiency, recyclable scrap, economical material, stable product quality and light specific gravity.

### TPE 產品適用範圍：

#### 鞋類：

各式鞋底、鞋跟、鞋後套、鞋面及鞋面裝飾品。

#### 運動器材：

潛水器材、握把、雪靴、玩具、飛盤及滑水器材。

#### 汽車零配件：

雨刷膠條、安全帶套、防護罩、隔音板、輪弧蓋、車身飾條、空氣導管、軸套、方向盤保險桿及附件。

#### 工業用製品：

電腦電話用鍵盤、排水管墊圈、橡膠滾輪、工具用把手、膠管接頭、泛用軟管、噴水蓮蓬頭旋鈕。

#### 家用製品：

浴室止滑墊、馬桶零配件、冰箱封條、門窗氣密封條、止滑地磚、密封罐墊圈、碗墊、杯墊、隔熱墊、椅墊、腳踏墊。

醫療器材：針筒塞、熱水瓶零件、拋棄型奶嘴、幼兒咬環、防毒面具。

#### 其它：

塑膠改質劑、粘著劑、建材填縫材。



### TPE產品特性：

1. 高抗張及低壓縮變型。
2. 低加工成本。
3. 易加工 / 免加硫。
4. 橡膠觸感佳。
5. 機械性能良好。
6. 百分之百回收。
7. 耐低溫特性。
8. 耐藥品性。
9. 延伸性佳。
10. 耐候性佳。

### TPE product features

1. High tensile and low compression variants.
2. Low processing costs.
3. Easy to process / free of sulfur.
4. The rubber feels good.
5. Good mechanical properties.
6. 100% recycling
7. Low temperature resistance
8. Chemical resistance
9. Excellent extensibility
10. Good weather resistance

### TPE product scope:

#### Footwear:

Various soles, heels, heel sets, uppers and uppers.

#### Sports Equipment:

Diving equipment, grips, snow boots, toys, Frisbee and water ski equipment.

#### automobile parts:

Wiper strips, seat belt covers, protective covers, baffles, wheel covers, body trims, air ducts, bushings, steering wheel bumpers and accessories.

#### Industrial products:

Computer phone keyboard, drain gasket, rubber roller, tool handle, hose connector, universal hose, water spray nozzle knob.

#### Household products:

Bathroom slip pads, toilet parts, refrigerator seals, door and window air seals, slip floor tiles, sealed can gaskets, bowl mats, coasters, pad cushions, foot mats.

Medical equipment: syringe thermos parts, disposable nipples, toddler bites, gas masks.

#### other:

Plastic modifiers, adhesives, building materials and joint fillers.

TPE 是一類具有橡膠彈性同時無需硫化，可直接加工成型（如注塑，擠出，吹塑等）的熱塑性軟性膠料。TPE塑膠原料，是一種具有橡膠的高彈性，高強度，高回彈性，又具有可注塑加工的特徵，具有環保無毒安全，硬度範圍廣，有優良的著色性。

TPE is a kind of thermoplastic soft rubber compound which has rubber elasticity and does not need vulcanization and can be directly processed (such as injection molding, extrusion, blow molding, etc.). TPE plastic raw material is a kind of rubber with high elasticity, high strength, high resilience and injection molding processing. It has environmental protection, non-toxic safety, wide hardness range and excellent coloring.

## TPE raw material characteristics

### TPE 應用特性：

1. 環保無毒安全
2. 硬度範圍廣
3. 觸感優異柔軟
4. 優良的著色性、耐候性、抗疲勞性和耐溫性
5. 比重小，加工性能優越，無須硫化
6. 可以回收使用，降低產品成本
7. 替代橡膠，軟質 PVC 和部分矽橡膠
8. 可以二次注塑成型，與 PP, PS, PE, PC, PA, ABS 等基體材料包覆粘合，也可以單獨成型，可用於塑膠增強性能、增韌改性。自補強性大，配方簡化，助劑對聚合物的影響制約性小，質量性能更易掌握。TPE 的優點十分突出，各種新型的 TPE 產品也不斷開發出來。作為一種節能環保的橡膠新型原料。

### TPE application features:

1. Environmentally friendly, non-toxic and safe
2. Wide range of hardness
3. Excellent touch and softness
4. Excellent coloring, weather resistance, fatigue resistance and temperature resistance
5. Small specific gravity, superior processing performance, no need to cure
6. Can be recycled to reduce product cost
7. Replacement rubber, soft PVC and some enamel rubber
8. It can be over-molded and coated with PP, PS, PE, PC, PA, ABS and other base materials. It can also be molded separately and can be used for plastic reinforcement and toughening modification. The self-reinforcing property is large, the formula is simplified, the influence of the auxiliary agent on the polymer is small, and the quality performance is easier to grasp. The advantages of TPE are outstanding, and various new TPE products are also being developed. As a new energy-saving and environmentally friendly rubber raw material.



# KALLOY® TPE

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05 TPE AB系列

TPE AB series

06 TPE H系列

TPE H series

07 TPE L系列

TPE L series

08 TPE M系列

TPR M series



## TPE AB 系列

### TPE AB series



#### • 包覆性佳

特殊規格等級，PC / ABS / 包覆射出成型：  
在擠出成型、注塑成型應用非常普遍，非常適合在其他塑料上進行注塑包覆。

#### • Good coverage

Special specification grade, PC / ABS / coated injection molding:

Injection molding applications are very common in extrusion molding and are ideal for injection molding on other plastics.

| 型號/規格    | 檢測方法       | 單位                  | AB-655A                | AB-660A | AB-670A | AB-675A | AB-680A | AB-685A |
|----------|------------|---------------------|------------------------|---------|---------|---------|---------|---------|
| 比重       | ASTM D792  | -                   | 1.02                   | 1.09    | 1.09    | 1.09    | 1.09    | 1.09    |
| 硬度A      | ASTM D2240 | Shoer A             | 55                     | 60      | 70      | 75      | 80      | 85      |
| 拉力強度     | ASTM D412  | kgf/cm <sup>2</sup> | 48                     | 80      | 85      | 95      | 115     | 110     |
| 伸長率      | ASTM D412  | kgf/cm <sup>2</sup> | 500                    | 650     | 700     | 600     | 600     | 650     |
| 100%抗拉模數 | ASTM D412  | kgf/cm <sup>2</sup> | 20                     | 25      | 28      | 40      | 53      | 60      |
| 300%抗拉模數 | ASTM D412  | kgf/cm <sup>2</sup> | 38                     | 40      | 45      | 55      | 70      | 75      |
| 撕裂強度     | ASTM D624  | kgf/cm              | 40                     | 50      | 58      | 65      | 70      | 75      |
| 特性       | -          | -                   | PC/ABS/Ovre Molding 接着 |         |         |         |         |         |



## TPE H 系列

### TPE H series



熱塑性橡膠為熱可塑性複合材料，簡稱 TPE具有柔軟的觸感與可調整的物性與硬度，能直接注塑或擠出成型，邊料溢料均可回收，降低生產成本，它既有熱塑料的易加工性能，又具有熱固性橡膠的性能，節省能源及響應綠色環保的潮流。

#### 產品應用：

蛙鞋、海灘鞋、煞車皮、止滑墊片、手工具握把、自行車握把、避震片、油封、防護軟墊。

Thermoplastic rubber is a thermoplastic composite material. For short, TPE has soft touch and adjustable physical properties and hardness. It can be directly injection molded or extruded. The material can be recycled and the production cost can be reduced. It has the advantages of hot plastic. Processing performance, but also the performance of thermoset rubber, saving energy and responding to the trend of green.

#### Product application:

Fins, beach shoes, brake pads, anti-slip pads, hand tool grips, bicycle grips, shock absorbers, oil seals, protective cushions.

| 型號/規格    | 檢測方法       | 單位      | H-910A | H-935A | H-950A | H-957A | H-970A | H-990A |
|----------|------------|---------|--------|--------|--------|--------|--------|--------|
| 比重       | ASTM D792  | -       | 0.87   | 0.87   | 0.87   | 0.87   | 0.87   | 0.87   |
| 硬度A      | ASTM D2240 | Shoer A | 10     | 35     | 50     | 57     | 70     | 90     |
| 拉力強度     | ASTM D412  | kgf/cm² | 18     | 30     | 35     | 37     | 48     | 85     |
| 伸長率      | ASTM D412  | kgf/cm² | 500    | 400    | 360    | 380    | 400    | 480    |
| 100%抗拉模數 | ASTM D412  | kgf/cm² | 8      | 17     | 20     | 25     | 40     | 60     |
| 300%抗拉模數 | ASTM D412  | kgf/cm² | 13     | 22     | 25     | 30     | 45     | 70     |
| 撕裂強度     | ASTM D624  | kgf/cm  | 9      | 18     | 25     | 30     | 45     | 75     |
| 特性       | -          | -       | 氫化透明級  |        |        |        |        |        |



TPE L 系列

TPE L series



**透明等級：**  
具有高透明和超強韌性。在擠出成型、注塑成型應用非常普遍，可以滿足產品透明的要求。

**Special transparency grade :**  
High transparency and superior toughness. Injection molding applications are very common in extrusion molding to meet product transparency requirements.

| 型號/規格    | 檢測方法       | 單位      | L-935A | L-945A | L-955A | L-960A | L-948A | L-958A |
|----------|------------|---------|--------|--------|--------|--------|--------|--------|
| 比重       | ASTM D792  | -       | 0.9    | 0.92   | 0.92   | 0.92   | 0.92   | 0.93   |
| 硬度A      | ASTM D2240 | Shoer A | 35     | 45     | 55     | 60     | 48     | 58     |
| 拉力強度     | ASTM D412  | kgf/cm² | 28     | 50     | 60     | 80     | 58     | 63     |
| 伸長率      | ASTM D412  | kgf/cm² | 600    | 1000   | 1000   | 880    | 1000   | 960    |
| 100%抗拉模數 | ASTM D412  | kgf/cm² | 14     | 22     | 25     | 28     | 15     | 16     |
| 300%抗拉模數 | ASTM D412  | kgf/cm² | 18     | 28     | 35     | 35     | 20     | 31     |
| 撕裂強度     | ASTM D624  | kgf/cm  | 25     | 40     | 45     | 48     | 38     | 40     |
| 特性       | -          | -       | 一般透明級  |        |        |        | 高透回彈級  |        |





## TPE M 系列

### TPE M series

#### 通用等級：

在擠出成型、注塑成型應用非常普遍，且通用。

#### • General level:

It is very common and common in extrusion molding and injection molding applications.

#### 產品應用：

蛙鞋、海灘鞋、煞車皮、止滑墊片、手工具握把、自行車握把、避震片、油封、防護軟墊。

#### • Applications:

Fins, beach shoes, brake pads, anti-slip pads, hand tool grips, bicycle grips, shock absorbers, oil seals, protective cushions.

| 型號/規格    | 檢測方法       | 單位                  | M-615A | M-645A | M-655A | M-665A | M-675A | M-675A |
|----------|------------|---------------------|--------|--------|--------|--------|--------|--------|
| 比重       | ASTM D792  | -                   | 1.03   | 1.07   | 1.07   | 1.08   | 1.07   | 1.06   |
| 硬度A      | ASTM D2240 | Shoer A             | 15     | 45     | 55     | 65     | 75     | 85     |
| 拉力強度     | ASTM D412  | kgf/cm <sup>2</sup> | 20     | 25     | 26     | 35     | 55     | 62     |
| 伸長率      | ASTM D412  | kgf/cm <sup>2</sup> | 350    | 400    | 400    | 450    | 530    | 550    |
| 100%抗拉模數 | ASTM D412  | kgf/cm <sup>2</sup> | 10     | 18     | 21     | 28     | 40     | 50     |
| 300%抗拉模數 | ASTM D412  | kgf/cm <sup>2</sup> | 15     | 25     | 25     | 32     | 48     | 55     |
| 撕裂強度     | ASTM D624  | kgf/cm              | 15     | 20     | 24     | 32     | 50     | 60     |
| 特性       | -          | -                   | 泛用級    |        |        |        |        |        |



技術支援、參考資料、客製化服務

# Abnormal Handling In Injection Molding

## 在注塑成型中的異常處理

TPE的成型工藝有多種方法，其中以注塑為常用。 注塑前需注意以下幾點：

- 1.根據材料的收縮率來設計模具結構。
- 2.回收料的合理配比及機臺停機時的清潔處理。

There are many methods for forming a TPE, in which injection molding is commonly used. Pay attention to the following points before injection molding:

- 1. Design the mold structure according to the shrinkage rate of the material.
- 2. Reasonable ratio of recycled materials and cleaning treatment when the machine is shut down.

| 注塑成型溫度參考 (單位°C)     |        | Injection molding temperature reference (unit °C) |                          |                  |
|---------------------|--------|---------------------------------------------------|--------------------------|------------------|
| 型號/規格               | 噴嘴     | C3(計量段)                                           | C2(壓縮段)                  | C1(進料段)          |
| Model/Specification | Nozzle | C3(Metering section)                              | C2(Compressiong section) | C1(Feed section) |
| 35                  | 160    | 155                                               | 150                      | 150              |
| 65                  | 170    | 165                                               | 160                      | 160              |
| 95                  | 180    | 175                                               | 170                      | 170              |

★ 以上溫度僅供參考，請依現況調整

| 不良現象  | 解決方法                                                               | 不良現象   | 解決方法                                                                         |
|-------|--------------------------------------------------------------------|--------|------------------------------------------------------------------------------|
| 匯交線   | 1.增加注塑機的壓力<br>2.增加熔料溫度或噴嘴溫度<br>3.增加澆口尺寸或改變位置<br>4.改善排氣孔            | 螺桿打滑   | 1.降低螺桿入料溫度<br>2.添加回收率<br>3.降低料筒溫度<br>4.排除螺桿進料段故障<br>5.確認添加擴散油是否過量            |
| 韌性不夠  | 1.熔料溫度太低或過熱<br>2.降低回收料比例<br>3.材料充分乾燥<br>4.增加澆口尺寸                   | 成品有氣泡  | 1.材料充分乾燥<br>2.改善模具設計<br>3.增加注塑機的背壓<br>4.降低料筒溫度                               |
| 成品焦化  | 1.降低熔料溫度<br>2.降低回收料比例<br>3.模具排氣不暢<br>4.重新清洗螺桿、噴嘴、料筒                | 表面噴紋   | 1.加大澆口尺寸與溫度<br>2.材料充分乾燥<br>3.降低注塑速度或溫度<br>4.模具型腔損傷                           |
| 毛邊現象  | 1.降低注塑壓力<br>2.降低熔膠溫度<br>3.提高合模壓力與機臺噸位<br>4.改善模具缺陷                  | 成品翹曲   | 1.降低模具溫度<br>2.增加注塑壓力<br>3.改善澆口位置<br>4.降低注塑速度<br>5.增加保壓時間                     |
| 成品有凹陷 | 1.增加注塑壓力與機臺噸位<br>2.增加計量或保壓時間<br>3.檢查止逆閥<br>4.加強排氣<br>5.降低熔料溫度或注塑速度 | 成品脫模困難 | 1.降低注塑壓力<br>2.降低保壓時間<br>3.增加滑劑或噴脫膜劑<br>4.改善模具缺陷<br>5.改變澆口位置與尺寸<br>6.增大模具拔模角度 |

# Abnormal Handling In Extrusion

## 在擠出成型中的異常處理

擠出成型工藝可製成塑料管材、板材、帶材、異型材、棒材、薄膜等。

在擠出加工前需注意以下幾點：

- 1.根據材料硬度、粘度來設定加工溫度。
- 2.根據材料特性考慮螺桿結構和長徑比。

The extrusion process can be made into plastic pipes, plates, strips, profiles, bars, films, and the like.

Pay attention to the following points before re-extrusion processing:

1. Set the processing temperature according to the hardness of the material.
2. Consider the screw structure and length to diameter ratio according to the material characteristics.

| 擠出成型溫度參考 (單位°C)     |        | Extrusion temperature reference (unit °C) |                          |                  |
|---------------------|--------|-------------------------------------------|--------------------------|------------------|
| 型號/規格               | 噴嘴     | C3(計量段)                                   | C2(壓縮段)                  | C1(進料段)          |
| Model/Specification | Nozzle | C3(Metering section)                      | C2(Compressiong section) | C1(Feed section) |
| 35                  | 160    | 155                                       | 150                      | 150              |
| 65                  | 170    | 165                                       | 160                      | 160              |
| 95                  | 180    | 175                                       | 170                      | 170              |

★ 以上溫度僅供參考，請依現況調整

| 不良現象  | 解決方法                                                           | 不良現象 | 解決方法                                                       |
|-------|----------------------------------------------------------------|------|------------------------------------------------------------|
| 皺紋    | 1.提高模頭溫度與加工溫度<br>2.降低冷卻水溫<br>3.排除模頭有損傷或雜質                      | 氣泡   | 1.材料充分乾燥<br>2.芯線夾入空氣<br>3.吃料不順暢<br>4.降低成型溫度                |
| 接合線   | 1.提高加工溫度<br>2.提高模頭內膜壓力<br>3.調整機頭位置與溫度<br>4.材料充分乾燥              | 表面偏亮 | 1.成型溫度太高<br>2.提高水槽溫度<br>3.生產速度太慢<br>4.降低眼模溫度               |
| 表面太霧  | 1.提高成型溫度<br>2.降低螺桿速度<br>3.材料充分乾燥<br>4.提高眼模溫度<br>5.降低冷凍水溫度      | 有滯留物 | 1.模頭溫度過低<br>2.材料粘度太高<br>3.材料受污染<br>4.材料焦化                  |
| 透明性差  | 1.提高成型溫度<br>2.降低螺桿速度或水槽溫度<br>3.選擇透明級材料<br>4.材料含水分高<br>5.滑劑添加過量 | 黑點   | 1.模頭殘料滯留<br>2.清洗螺桿<br>3.更換過濾網<br>4.成型溫度太高材料焦化<br>5.材料受污染   |
| 尺寸不穩定 | 1.材料有雜質<br>2.溫度太高或入料不順<br>3.牽引太快<br>4.模頭有損傷<br>5.材料含水分         | 不熔顆粒 | 1.降低加工速度<br>2.提高加工溫度<br>3.排除材料污染<br>4.清理模頭與螺桿<br>5.增加過濾網目數 |

# Standard Specification Comparison Table

## 標準規範對照表

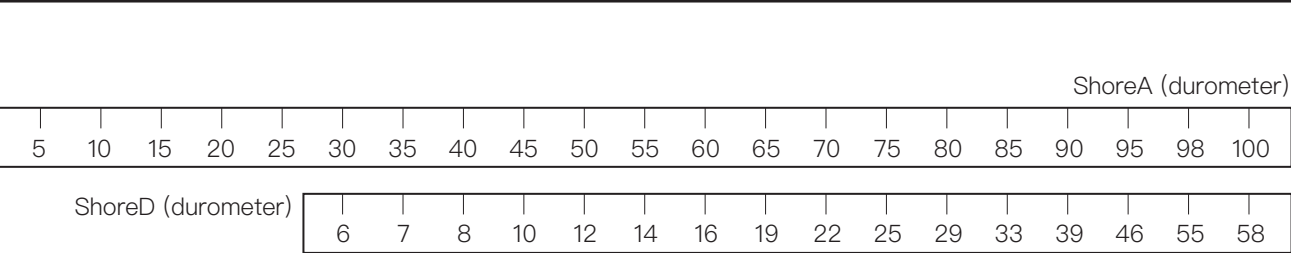
| 型號/規格 | Model/Specification  | ASTM   | DIN   | ISO  | Comparability            |
|-------|----------------------|--------|-------|------|--------------------------|
| 比重    | Specific Gravity     | D-792  | 53479 | 2781 | All comparable           |
| 硬度    | Hardness             | D-2240 | 53505 | 868  | All comparable           |
| 熔融指數  | MFI                  | D-1238 | 53735 | 1133 | All comparable If 2.16kg |
| 抗張程度  | Tensile Strength     | D-412  | 53455 | 37   | All comparable           |
| 彎曲模數  | Flexural Modulus     | D-790  | 53452 | 178  | ISO and ASTM comparable  |
| 撕裂強度  | Tear Strength        | D-624  | 53515 | 34   | All comparable           |
| 模縮系數  | Mold Shrinkage       | D-955  | 53464 | 294  | All comparable           |
| 衝擊強度  | IZOD Impact Strength | D-256  | 53453 | 180  | ASTM and ISO comparable  |
| 磨耗    | Abrasion Loss        | D-5963 | 53516 | 4649 | All comparable           |

參考資料

Unit Conversion Table  
單位換算表

| bar  | Mpa   | Psi  | kg/cm <sup>2</sup> | N/mm <sup>2</sup> |
|------|-------|------|--------------------|-------------------|
| 1    | 0.1   | 14.5 | 1                  | 0.1               |
| 10   | 1     | 145  | 10                 | 1                 |
| 0.07 | 0.007 | 1    | 0.07               | 0.007             |

ShoreA、D Hardness Comparison Table  
ShoreA、D 硬度對照表



## Customized service

### 客製化服務

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為求使客戶的產品條件達到最佳物性，我們的研發團隊以服務客戶達到條件最佳化一直以來都是我們最注重的領域之一。

客製化條件例如阻燃性、導電性、抗 UV、耐磨性等等，皆可在不同層面之需求量身訂做提供客戶最佳的產品條件。或者針對各項專業領域對客戶提出最佳解決方案。

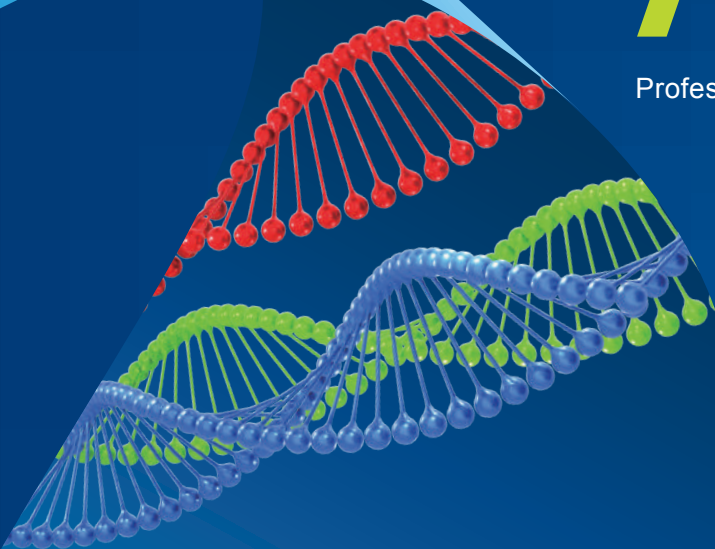
In order to achieve the best physical condition of our customers' products, our R&D team has always been one of our most important areas to meet the conditions of serving customers.

Customized conditions such as flame retardancy, electrical conductivity, UV resistance, abrasion resistance, etc., can be tailored to meet the needs of different levels to provide customers with the best product conditions. Or advise customers on the optimization of each area of expertise.



# TPE

Professional Manufacturing Factory



**崑仲股份有限公司**

KIN JOIN CO., LTD.  
KINJOIN **KOSLEN® TPU** **KALLOY® TPE**

412 台中市大里區仁化路166號  
No.166, Renhua Rd., Dali Dist., Taichung City 412,  
Taiwan (R.O.C.)  
TEL : +886-4-24916138  
FAX : +886-4-24919990



[www.tpu.tw](http://www.tpu.tw)



**普立优高分子有限公司**

POLYOL POLYMER CO., LTD.  
POLYU **KOSLEN® TPU** **KALLOY® TPE**

泉州市惠安縣網川鎮石化輕工小區  
Wangchuan Town, Hui'an County, Quanzhou City, China  
TEL : +86-595-87250688  
FAX : +86-595-87256769



[www.tpu-polyol.com](http://www.tpu-polyol.com)



**东莞市昆胜塑胶制品有限公司**

Dongguan KUNSON Plastic Products Company Limited.  
POLYU **KOSLEN® TPU** **KALLOY® TPE**

東莞市厚街鎮白濠村深溪路35號  
No. 35, Shenxi Road, Bailu Village, Houjie Town,  
Dongguan City  
TEL : 0769-85961010  
FAX : 0769-85891010



[www.tpu-polyol.com](http://www.tpu-polyol.com)