Monprene® RG-18240

Teknor Apex Company - Thermoplastic Elastomer

Monday, March 30, 2015

General Information

General			
Generic Name	• Thermoplastic Elastomer (TPE)		
Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Closures • Consumer Applications • Gaskets • Handles	• Kitchenware • Packaging • Safety Equipment • Sporting Goods	• Toothbrush Handles • Tubing • Writing Instruments
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	0.890	g/cm³	ISO 1183
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (100% Strain)	1.19	MPa	ISO 37
Tensile Stress (300% Strain)	1.71	MPa	ISO 37
Tensile Strength (Break)	7.60	MPa	ISO 37
Tensile Elongation (Break)	900	%	ISO 37
Compression Set			ISO 815
23°C, 22 hr	23	%	
70°C, 22 hr	40	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 5 sec)	40		ISO 868
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (200°C, 206 sec^-1)	101	Pa·s	ISO 11443

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	120 to 160	°C
Middle Temperature	160 to 230	°C
Front Temperature	180 to 230	°C
Nozzle Temperature	180 to 230	°C
Processing (Melt) Temp	180 to 230	°C
Mold Temperature	15.0 to 50.0	°C
Injection Rate	Fast	
Back Pressure	0.500 to 1.50	MPa
Screw Speed	50 to 100	rpm
Cushion	3.00 to 25.0	mm

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Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 65°C (150°F).
Low holding pressure is recommended

Notes

[1] Typical properties: these are not to be construed as specifications.