

Monprene® PC-13940 XRD1 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene PC-13940 XRD1 is a high performance thermoplastic elastomer, available in NAT and colors, designed for a variety of personal care consumer product applications requiring a soft, rubber-like feel, including toothbrush articles. Monprene PC-13940 XRD1 is a low hardness, medium density, UV stabilized grade that complies with various US FDA and European regulations and directives for food contact and is suitable for injection molding.

General Information	
Features	UV Stabilized Workability, good Good coloring Good adhesion Lubrication Compliance of Food Exposure Fill Hardness, low Medium density
Uses	Cosmetic Packaging Handle Kitchen utensils Washer Non-specific food applications Cover Food packaging Food service sector Food container Shell Toys Rubber substitution Consumer goods application field Toothbrush handle
Agency Ratings	FDA Food Exposure, Not Rated European food contact, not rated
RoHS Compliance	RoHS compliance

Appearance	Opacity Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	40		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	1.00	MPa	ISO 37
300% strain	1.60	MPa	ISO 37
Tensile Strength (Break)	7.30	MPa	ISO 37
Tensile Elongation (Break)	900	%	ISO 37
Compression Set ¹			ISO 815
23°C, 22 hr	21	%	ISO 815
70°C, 22 hr	39	%	ISO 815
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	109	Pa · s	ISO 11443

Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	120 - 160	°C
Middle Temperature	160 - 230	°C
Front Temperature	180 - 230	°C
Nozzle Temperature	180 - 230	°C
Processing (Melt) Temp	180 - 230	°C
Mold Temperature	15 - 50	°C
Injection Rate	Fast	
Back Pressure	0.500 - 1.50	MPa
Screw Speed	50 - 100	rpm
Cushion	3.00 - 20.0	mm

Injection instructions

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

NOTE

1. Method B

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