

Monprene® IN-22058 XRD (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene IN-22058 is a general purpose thermoplastic elastomer designed for the industrial market. Monprene IN-22058 is a medium density, medium hardness grade that is suitable for injection molding and extrusion.

General Information	
Features	Low liquidity
	Fill
	Medium density
	Medium hardness
Uses	Handle
	Washer
	Industrial application
	Pipe fittings
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	60		ASTM D2240
Shaw A, 5 seconds	58		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	1.27	MPa	ASTM D412
Flow: 100% strain ²	1.85	MPa	ASTM D412
Transverse flow: 300% strain ³	2.17	MPa	ASTM D412
Flow: 300% strain ⁴	3.17	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	7.62	MPa	ASTM D412
Flow: Fracture	4.85	MPa	ASTM D412

Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	640	%	ASTM D412
Flow: Fracture	650	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	28.9	kN/m	ASTM D624
Flow	21.9	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	18	%	ASTM D395B
70°C, 22 hr	42	%	ASTM D395B

Injection	Nominal Value	Unit
Rear Temperature	182 - 232	°C
Middle Temperature	188 - 238	°C
Front Temperature	193 - 243	°C
Nozzle Temperature	199 - 249	°C
Processing (Melt) Temp	199 - 249	°C
Mold Temperature	35.0 - 48.9	°C
Injection Pressure	1.38 - 5.52	MPa
Injection Rate	Fast	
Back Pressure	0.172 - 0.689	MPa
Screw Speed	50 - 100	rpm
Cushion	3.81 - 25.4	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).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	182 - 232	°C
Cylinder Zone 2 Temp.	188 - 238	°C
Cylinder Zone 3 Temp.	193 - 243	°C
Cylinder Zone 5 Temp.	199 - 249	°C
Die Temperature	199 - 249	°C

Extrusion instructions

Screw Speed: 30 to 100 rpm

NOTE

1. Mouth die C, 510mm/min
2. Mouth die C, 510mm/min
3. C mold, 510mm/min
4. C mold, 510mm/min
5. C mold, 510mm/min
6. Mouth die C, 510mm/min
7. C mold, 510mm/min
8. Type 1

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