

Monprene® IN-15065

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene IN-15065 is a general purpose thermoplastic elastomer designed for the industrial market. Monprene IN-15065 is a medium hardness, low density grade that exhibits low flow characteristics and is suitable for injection molding and extrusion.

General Information	
Features	Low Specific Gravity
	Without Fillers
	Low density
	Low liquidity
	Medium hardness
Uses	Handle
	Washer
	Industrial application
	Pipe fittings
	Stationery
	Consumer goods application field
Appearance	Clear/transparent
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	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
Shore A, 1 second, injection molding	67		ASTM D2240
Shore A, 5 seconds, injection molding	65		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.62	MPa	ASTM D412
Flow: 100% strain ²	3.85	MPa	ASTM D412
Transverse flow: 300% strain ³	4.69	MPa	ASTM D412
Flow: 300% strain ⁴	6.02	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412

Transverse flow: Fracture	11.7	MPa	ASTM D412
Flow: Fracture	7.01	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	660	%	ASTM D412
Flow: Fracture	440	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	50.1	kN/m	ASTM D624
Flow	38.5	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	18	%	ASTM D395B
70°C, 22 hr	88	%	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

无需干燥.但如果湿度过大,则将粒料在150°F (65°C)的温度下干燥2-4小时.

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

螺杆转速30 - 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

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

