

Monprene® RG-17260 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

The Monprene RG-17200 series is a group of high performance thermoplastic elastomers specifically designed for EU injection molded regulated applications including food contact, toys, and children's products. Monprene RG-17260 is a medium density, medium hardness grade that complies with various US FDA and European regulations and directives for food contact and toy safety and is suitable for injection molding. Please contact Teknor Apex for a regulatory compliance letter.

General Information	
Features	Workability, good
	Good coloring
	Good adhesion
	Lubrication
	Compliance of Food Exposure
	Fill
	Medium density
	Medium hardness
Uses	Cosmetic Packaging
	Safety equipment
	Handle
	Packaging
	Kitchen utensils
	Washer
	Pipe fittings
	Sporting goods
	Shell
	Stationery
	Consumer goods application field
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)	60		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	2.00	MPa	ISO 37
300% strain	2.10	MPa	ISO 37
Tensile Strength (Break)	8.00	MPa	ISO 37
Tensile Elongation (Break)	800	%	ISO 37
Compression Set ¹			ISO 815
23°C, 22 hr	26	%	ISO 815
70°C, 22 hr	47	%	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).

Extrusion instructions

Screw Speed: 30 to 100 rpm

NOTE

- Method B

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