

Monprene® MP-1500

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene MP-1500 is a thermoplastic elastomer designed for the consumer market. Monprene MP-1500 is a clear, medium hardness grade that exhibits low compression set, good abrasion and chemical resistance, and is suitable for injection molding and extrusion.

General Information			
Features	Low compressive deformability		
	Good melt strength		
	Good tear strength		
	Good coloring		
	Good wear resistance		
	Good chemical resistance		
	Good weather resistance		
Uses	Safety equipment		
	Handle		
	Packaging		
	Kitchen utensils		
	Large household appliances and small household appliances		
	Washer		
	Household goods		
	Fatigue elimination supplies		
	Outdoor application		
	Stationery		
	Rubber substitution		
	Consumer goods application field		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.890	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	65		ASTM D2240
Shaw A, 5 seconds	63		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	2.34	MPa	ASTM D412
200% strain	3.06	MPa	ASTM D412
300% strain	3.97	MPa	ASTM D412
Tensile Strength (Break)	14.8	MPa	ASTM D412
Tensile Elongation (Break)	730	%	ASTM D412
Tear Strength ¹			ASTM D624
Transverse flow: 23°C	33.0	kN/m	ASTM D624
Flow: 23°C	33.7	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	11	%	ASTM D395

Legal statement

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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 - 49	°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 4 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. C mold, 510mm/min

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