

Monprene® IN-12985

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® IN-12985 is a thermoplastic elastomer (TPE) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is extrusion or injection molding.

Monprene® The main features of IN-12985 are:

- high hardness
- daylight resistance

Typical application areas include:

- engineering/industrial accessories
- industrial applications

- Hose
- Handle

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Low density		
	Light stabilization		
	Low liquidity		
	Fill		
	High hardness		
	UV absorption		
Uses	Handle		
	Washer		
	Industrial application		
	Pipe fittings		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.938	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	89		ASTM D2240
Shore A, 5 seconds, injection molding	85		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method

Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	4.38	MPa	ASTM D412
Flow: 100% strain ²	5.32	MPa	ASTM D412
Transverse flow: 300% strain ³	5.54	MPa	ASTM D412
Flow: 300% strain ⁴	6.74	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	22.2	MPa	ASTM D412
Flow: Fracture	15.2	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	850	%	ASTM D412
Flow: Fracture	700	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	61.1	kN/m	ASTM D624
Flow	59.7	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	34	%	ASTM D395B
70°C, 22 hr	57	%	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

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