

Monprene® CP-29992

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-29992 is a high performance lubricated thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-29992 is a high hardness grade that exhibits sunlight resistance and UV absorbing characteristics, suitable for injection molding and extrusion.

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Without Fillers		
	Low density		
	smoothness		
	Light stabilization		
	Low liquidity		
	Lubrication		
	High hardness		
	UV absorption		
Uses	Safety equipment		
	Handle		
	Washer		
	Pipe fittings		
	Sporting goods		
	Stationery		
	Consumer goods application field		
Appearance	Opacity		
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) (230°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	94		ASTM D2240
Shore A, 5 seconds, injection molding	92		ASTM D2240

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	7.18	MPa	ASTM D412
Flow: 100% strain ²	9.88	MPa	ASTM D412
Transverse flow: 300% strain ³	7.97	MPa	ASTM D412
Flow: 300% strain ⁴	11.4	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	17.0	MPa	ASTM D412
Flow: Fracture	14.0	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	760	%	ASTM D412
Flow: Fracture	480	%	ASTM D412
Compression Set ⁷			ASTM D395B
23°C, 22 hr	36	%	ASTM D395B
70°C, 22 hr	55	%	ASTM D395B

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	35.0 - 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.	Type 1

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