

Monprene® RG-20180 X (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene RG-20180 is specifically designed for regulated applications including food contact, toys, and children's products. This grade is suitable for extrusion. Monprene RG-20180 complies with various US FDA and European regulations and directives for food contact and toy safety. Please contact Teknor Apex for a regulatory compliance letter.

General Information			
Features	Low Specific Gravity		
	Without Fillers		
	Low density		
	smoothness		
	Low liquidity		
	Lubrication		
	Compliance of Food Exposure		
	BPA-free		
	No kinetic components		
	High hardness		
Uses	Cosmetic Packaging		
	Kitchen utensils		
	Non-specific food applications		
	Cover		
	Food packaging		
	Food service sector		
	Food container		
	Toys		
	Consumer goods application field		
Agency Ratings	FDA Food Exposure, Not Rated		
	European food contact, not rated		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	0.888	g/cm³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	80		ISO 868
Elastomers	Nominal Value	Unit	Test Method

Tensile Stress ¹			ISO 37
Transverse flow: 100% strain	2.80	MPa	ISO 37
Flow: 100% strain	6.00	MPa	ISO 37
Tensile Stress ²			ISO 37
Transverse flow: Fracture	12.0	MPa	ISO 37
Flow: Fracture	7.00	MPa	ISO 37
Tensile Elongation ³			ISO 37
Transverse flow: Fracture	780	%	ISO 37
Flow: Fracture	250	%	ISO 37
Compression Set ⁴			ISO 815
23°C, 22 hr	23	%	ISO 815
70°C, 22 hr	35	%	ISO 815
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	303	Pa·s	ASTM D3835
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	149 - 160	°C	
Cylinder Zone 2 Temp.	160 - 204	°C	
Cylinder Zone 3 Temp.	171 - 216	°C	
Cylinder Zone 4 Temp.	182 - 227	°C	
Die Temperature	182 - 227	°C	
Extrusion instructions			
Screw Speed: 30 to 100 rpmDrying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150F (65C).			
NOTE			
1.	Type 1, 510mm/min		
2.	Type 1, 510mm/min		
3.	Type 1, 510mm/min		
4.	Type a		

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