

Monprene® IN-15056

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene IN-15056 is a thermoplastic elastomer designed for the industrial market. Monprene IN-15056 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	Roof Vents		
	Large household appliances and small household appliances		
	Washer		
	Industrial application		
	Pipe		
	Pipe seal		
	Building materials		
	Doors and Windows		
	Fatigue elimination supplies		
	Expansion Joint		
	Outdoor application		
	Rubber substitution		
	Potable water application		
	Assembled glass		
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
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.	C mold, 510mm/min		

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