

Monprene® CP-18160

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® CP-18160 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.

Typical application areas include:

Handle
safety equipment
packing
kitchen utensils
engineering/industrial accessories

General Information			
Uses	Safety equipment Handle Packaging Kitchen utensils Washer Pipe fittings Sporting goods Shell Stationery Consumer goods application field Toothbrush handle Medical/nursing supplies		
Appearance	Clear/transparent		
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) (190°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	62		ASTM D2240
Shaw A, 5 seconds	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	3.00	MPa	ASTM D412

300% strain	3.80	MPa	ASTM D412
Tensile Strength (Break)	9.65	MPa	ASTM D412
Tensile Elongation (Break)	600	%	ASTM D412
Tear Strength	33.3	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	18	%	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

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