

Monprene® RG-17280 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

The Monprene RG-17200 series is a group of high performance thermoplastic elastomers specifically designed for EU injection molded regulated applications including food contact, toys, and children's products. Monprene RG-17280 is a medium density, medium hardness grade that complies with various US FDA and European regulations and directives for food contact and toy safety and is suitable for injection molding. Please contact Teknor Apex for a regulatory compliance letter.

General Information			
Features	Workability, good		
	Good coloring		
	Good adhesion		
	Lubrication		
	Compliance of Food Exposure		
	Fill		
	Medium density		
	Medium hardness		
Uses	Cosmetic Packaging		
	Kitchen utensils		
	Washer		
	Non-specific food applications		
	Cover		
	Food packaging		
	Food service sector		
	Food container		
	Shell		
	Toys		
	Rubber substitution		
	Consumer goods application field		
	Toothbrush handle		
	Grind cleaning materials		
RoHS Compliance	RoHS compliance		
Appearance	Opacity		
	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method

Density	1.05	g/cm ³	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			ISO 37
100% strain	3.40	MPa	ISO 37
300% strain	4.20	MPa	ISO 37
Tensile Strength (Break)	8.20	MPa	ISO 37
Tensile Elongation (Break)	600	%	ISO 37
Compression Set ¹			ISO 815
23°C, 22 hr	38	%	ISO 815
70°C, 22 hr	56	%	ISO 815
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec ⁻¹)	113	Pa · s	ISO 11443

Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	120 - 160	°C
Middle Temperature	160 - 230	°C
Front Temperature	180 - 230	°C
Nozzle Temperature	180 - 230	°C
Processing (Melt) Temp	180 - 230	°C
Mold Temperature	15 - 50	°C
Injection Rate	Fast	
Back Pressure	0.500 - 1.50	MPa
Screw Speed	50 - 100	rpm
Cushion	3.00 - 20.0	mm

Injection instructions

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

Extrusion instructions

Screw Speed: 30 to 100 rpm

NOTE

1. Method B

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