

Monprene® CP-29353 NAT XRD1

(PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:

Monprene® CP-29353 NAT XRD1 (PRELIMINARY DATA) 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.

Monprene® The main features of CP-29353 NAT XRD1 (PRELIMINARY DATA) are:

- ROHS certification
- high liquidity

Typical application areas include:

- engineering/industrial accessories
- Consumer goods
- Handle

General Information			
Features	Low Specific Gravity		
	Without Fillers		
	Low density		
	smoothness		
	High liquidity		
	Lubrication		
	General		
	Medium hardness		
Uses	Handle		
	Washer		
	Consumer goods application field		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	45	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	55		ASTM D2240

Shaw A, 5 seconds	53		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
Transverse flow: 100% strain	1.72	MPa	ASTM D412
Flow: 100% strain	3.14	MPa	ASTM D412
Transverse flow: 300% strain	2.90	MPa	ASTM D412
Flow: 300% strain	4.38	MPa	ASTM D412
Tensile Strength ²			ASTM D412
Transverse flow: Fracture	5.88	MPa	ASTM D412
Flow: Fracture	5.65	MPa	ASTM D412
Tensile Elongation ³			ASTM D412
Transverse flow: Fracture	690	%	ASTM D412
Flow: Fracture	540	%	ASTM D412
Tear Strength ⁴			ASTM D624
Transverse flow	32.0	kN/m	ASTM D624
Flow	24.9	kN/m	ASTM D624
Compression Set ⁵			ASTM D395B
23°C, 22 hr	20	%	ASTM D395B
70°C, 22 hr	77	%	ASTM D395B
Injection	Nominal Value	Unit	
Rear Temperature	127 - 149	°C	
Middle Temperature	138 - 160	°C	
Front Temperature	149 - 171	°C	
Nozzle Temperature	171 - 193	°C	
Processing (Melt) Temp	171 - 193	°C	
Mold Temperature	16 - 32	°C	
Injection Pressure	1.38 - 5.52	MPa	
Back Pressure	0.172 - 0.689	MPa	
Screw Speed	50 - 100	rpm	
Cushion	3.81 - 25.4	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	Nominal Value	Unit	
Cylinder Zone 1 Temp.	138 - 149	°C	
Cylinder Zone 2 Temp.	149 - 160	°C	
Cylinder Zone 3 Temp.	160 - 182	°C	
Cylinder Zone 5 Temp.	171 - 193	°C	
Die Temperature	182 - 204	°C	
Extrusion instructions			
Screw Speed: 30 to 100 rpm			
NOTE			
1.	C mold, 510mm/min		

2.	C mold, 510mm/min
3.	C mold, 510mm/min
4.	C mold, 510mm/min
5.	Type 1

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