

Monprene® TL-2563A

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® TL-2563A 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 injection molding.

Typical application areas include:

engineering/industrial accessories

industrial applications

Consumer goods

Handle

General Information			
Features	smoothness		
	Medium liquidity		
	Fill		
	Medium density		
	Medium hardness		
Uses	Handle		
	Washer		
	Industrial application		
	Consumer goods application field		
Appearance	Opacity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	73		ASTM D2240
Shore A, 5 seconds, injection molding	71		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.16	MPa	ASTM D412
Flow: 100% strain ²	3.36	MPa	ASTM D412
Transverse flow: 300% strain ³	3.07	MPa	ASTM D412
Flow: 300% strain ⁴	4.47	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412

Transverse flow: Fracture	10.8	MPa	ASTM D412
Flow: Fracture	6.85	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	790	%	ASTM D412
Flow: Fracture	550	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	32.4	kN/m	ASTM D624
Flow	30.1	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	22	%	ASTM D395B
70°C, 22 hr	44	%	ASTM D395B

Injection	Nominal Value	Unit
Rear Temperature	171 - 193	°C
Middle Temperature	177 - 199	°C
Front Temperature	182 - 204	°C
Nozzle Temperature	188 - 210	°C
Processing (Melt) Temp	188 - 210	°C
Mold Temperature	25.0 - 65.6	°C
Injection Pressure	1.38 - 6.89	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.172 - 0.345	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.	166 - 188	°C
Cylinder Zone 2 Temp.	171 - 193	°C
Cylinder Zone 3 Temp.	177 - 199	°C
Cylinder Zone 5 Temp.	182 - 204	°C
Die Temperature	190 - 210	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE

1. Mouth die C, 510mm/min
2. Mouth die C, 510mm/min
3. C mold, 510mm/min
4. C mold, 510mm/min
5. C mold, 510mm/min
6. Mouth die C, 510mm/min
7. C mold, 510mm/min
8. Type 1

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