

Monprene® OM-10230-01

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-10230-01 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.

Monprene® The main features of the OM-10230-01 are:

- flame retardant/rated flame
- low hardness
- Strong adhesion
- high liquidity
- daylight resistance

Typical application areas include:

- Handle
- engineering/industrial accessories
- Electrical/electronic applications
- electrical appliances
- Tools

General Information		
UL YellowCard	E54709-100177966	E142591-101723979
Features	Low Specific Gravity	
	Sunlight Resistant	
	Low density	
	smoothness	
	Light stabilization	
	Adhesiveness	
	High liquidity	
	Hardness, low	
Uses	Handle	
	overmolding	
	Electrical appliances	
	Power/other tools	
	Soft handle	
	Mobile phone	
	Sporting goods	
	Stationery	
	Knob	
	Dental application field	
	Toothbrush handle	
	Bonding	
Appearance	Opacity	

Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.958	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	2.6	%	ASTM D955
Transverse flow	1.9	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	34		ASTM D2240
Shaw A, 5 seconds	30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	1.72	MPa	ASTM D412
Tensile Strength (Break)	2.76	MPa	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Compression Set (23°C, 22 hr)	10	%	ASTM D395
Thermal	Nominal Value	Unit	Test Method
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 to 2.80mm, All Colors)	HB		UL 94
Additional Information	Nominal Value		
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	138 - 188	°C	
Middle Temperature	154 - 199	°C	
Front Temperature	154 - 216	°C	
Nozzle Temperature	154 - 221	°C	
Processing (Melt) Temp	166 - 221	°C	
Mold Temperature	10.0 - 32.2	°C	
Injection Pressure	1.38 - 5.52	MPa	
Back Pressure	0.172 - 0.862	MPa	
Screw Speed	50 - 100	rpm	
Cushion	3.81 - 25.4	mm	
Injection instructions			

潮湿会使材料降解.建议进行干燥处理.可以把材料放入除湿干燥机,在140°F的温度下干燥2-4小时.

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

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