

# Monprene® SP-13168

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® SP-13168 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 |                   |             |
| Appearance                               | Translucent                      |                   |             |
|                                          | Particle                         |                   |             |
| Forms                                    |                                  |                   |             |
|                                          |                                  |                   |             |
| Processing Method                        | Extrusion                        |                   |             |
|                                          | Injection molding                |                   |             |
| Physical                                 | Nominal Value                    | Unit              | Test Method |
| Specific Gravity                         | 0.948                            | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (200°C/5.0 kg) | 2.0                              | g/10 min          | ASTM D1238  |
| Hardness                                 | Nominal Value                    | Unit              | Test Method |
| Durometer Hardness (Shore A)             | 70                               |                   | ASTM D2240  |
| Elastomers                               | Nominal Value                    | Unit              | Test Method |
| Tensile Stress (300% Strain)             | 5.52                             | MPa               | ASTM D412   |
| Tensile Strength (Break)                 | 12.4                             | MPa               | ASTM D412   |
| Tensile Elongation (Break)               | 500                              | %                 | ASTM D412   |
| Compression Set (23°C)                   | 20                               | %                 | ASTM D395   |

| 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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#### Recommended distributors for this material

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