

Monprene® OM-10340 CLR

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-10340 CLR 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:

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

General Information			
Uses	Handle		
	overmolding		
	Electrical appliances		
	Power/other tools		
	Soft handle		
	Mobile phone		
	Sporting goods		
	Stationery		
	Knob		
	Dental application field		
	Toothbrush handle		
	Bonding		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.928	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	45	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	45		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	2.93	MPa	ASTM D412
Tensile Strength (Break)	6.89	MPa	ASTM D412
Tensile Elongation (Break)	750	%	ASTM D412
Additional Information	Nominal Value		
Adhesion to ABS			
Adhesion to HIPS			

Adhesion to PS

Injection	Nominal Value	Unit
Drying Temperature	65.6	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	188 - 238	°C
Middle Temperature	193 - 238	°C
Front Temperature	199 - 243	°C
Nozzle Temperature	204 - 249	°C
Processing (Melt) Temp	204 - 249	°C
Mold Temperature	15.6 - 32.2	°C
Injection Pressure	1.38 - 6.89	MPa
Injection Rate	Fast	
Back Pressure	0.172 - 0.862	MPa
Screw Speed	50 - 120	rpm
Cushion	3.81 - 25.4	mm

Injection instructions

For any overmolding process it is recommended that the process temperatures for the TPE material be set at least 10 degrees Celsius higher than the melt temperature of the substrate material.

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