

Monprene® CP-19234

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-19234 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-19234 is a low hardness, low density grade suitable for both injection molding and extrusion.

General Information			
Features	Low density		
	Workability, good		
	Good flexibility		
	Good adhesion		
	Good chemical resistance		
	Soft		
	Hardness, low		
Uses	Safety equipment		
	Handle		
	Packaging		
	Washer		
	Pipe fittings		
	Sporting goods		
	Shell		
	Stationery		
	Consumer goods application field		
RoHS Compliance	RoHS compliance		
	Toothbrush handle		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.880	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	23	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	37		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	5.00	MPa	ASTM D412

Tensile Elongation (Break)	600	%	ASTM D412
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Legal statement

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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 - 49	°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 4 Temp.	199 - 249	°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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