

# Monprene® MP-3020 XRD1 (PRELIMINARY DATA)

Thermoplastic Elastomer  
Teknor Apex Company

**Message:**  
Monprene MP-3020 XRD1 is a general purpose thermoplastic elastomer designed for a variety of consumer and industrial product applications requiring a soft, rubber-like feel. Monprene MP-3020 XRD1 is a medium density, high hardness grade which exhibits good flexibility and is suitable for injection molding.

General Information			
Features	High Flexibility		
	Good flexibility		
	Fill		
	High hardness		
	Medium density		
Uses	Handle		
	Washer		
	Furniture		
	General		
	Consumer goods application field		
RoHS Compliance	RoHS compliance		
Appearance	Opacity		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore D, 1 second, injection molding	33		ASTM D2240
Shore D, 5 seconds, injection molding	32		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	6.50	MPa	ASTM D412
Tensile Strength (Break)	7.70	MPa	ASTM D412
Tensile Elongation (Break)	400	%	ASTM D412

Compression Set (70°C, 22 hr)	78	%	ASTM D395
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec <sup>-1</sup> )	140	Pa·s	ASTM D3835

#### Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	182 - 204	°C
Middle Temperature	182 - 204	°C
Front Temperature	182 - 204	°C
Nozzle Temperature	182 - 204	°C
Processing (Melt) Temp	182 - 204	°C
Mold Temperature	16 - 32	°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

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

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