

# Monprene® CP-18270 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

The Monprene CP-18200 Unfilled, High Flow Series of thermoplastic elastomer compounds, with good UV resistance, available in NAT or colors, from 40 to 80 Shore A, are designed specifically for EU consumer product applications requiring a soft, rubber-like feel. Monprene CP-18270 is a medium hardness, low density grade that is suitable for injection molding.

General Information	
Features	Low Specific Gravity
	Without Fillers
	Low density
	Good UV resistance
	Good formability
	Good flexibility
	Good coloring
	Good adhesion
	High liquidity
	Good chemical resistance
	Good toughness
	Medium hardness
Uses	Handle
	overmolding
	Plug
	Bushing
	Washer
	Washer
	Leather case
	Soft touch application
	Soft handle
	General
	Rubber substitution
	Consumer goods application field
	Knob
RoHS Compliance	RoHS compliance
Appearance	Translucent
	Available colors
Forms	Particle

Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.890	g/cm <sup>3</sup>	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 5 sec)	70		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ISO 37
100% strain	2.20	MPa	ISO 37
300% strain	3.00	MPa	ISO 37
Tensile Strength (Break)	6.70	MPa	ISO 37
Tensile Elongation (Break)	500	%	ISO 37
Compression Set			ISO 815
23°C, 22 hr	31	%	ISO 815
70°C, 22 hr	55	%	ISO 815
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 206 sec <sup>-1</sup> )	104	Pa · s	ISO 11443

#### Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	120 - 160	°C
Middle Temperature	160 - 230	°C
Front Temperature	180 - 230	°C
Nozzle Temperature	180 - 230	°C
Processing (Melt) Temp	180 - 230	°C
Mold Temperature	15 - 50	°C
Injection Rate	Fast	
Back Pressure	0.500 - 1.50	MPa
Screw Speed	50 - 100	rpm
Cushion	3.00 - 25.0	mm

#### Injection instructions

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

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