

Monprene® OM-10240-02

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-10240-02 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.

Monprene® The main features of the OM-10240-02 are:

low hardness

high liquidity

Typical application areas include:

Handle

safety equipment

packing

kitchen utensils

engineering/industrial accessories

General Information	
Features	Low Specific Gravity Without Fillers Low density smoothness High liquidity Lubrication Hardness, low
Uses	Safety equipment Handle Packaging Kitchen utensils Washer Pipe fittings Sporting goods Shell Stationery Consumer goods application field Toothbrush handle Medical/nursing supplies
Appearance	Translucent
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.908	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (150°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	42		ASTM D2240
Shore A, 5 seconds, injection molding	40		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	0.765	MPa	ASTM D412
Flow: 100% strain ²	1.99	MPa	ASTM D412
Transverse flow: 300% strain ³	1.63	MPa	ASTM D412
Flow: 300% strain ⁴	4.17	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	9.80	MPa	ASTM D412
Flow: Fracture	6.32	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	590	%	ASTM D412
Flow: Fracture	510	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	32.4	kN/m	ASTM D624
Flow	19.6	kN/m	ASTM D624
Compression Set ⁸ (23°C, 22 hr)	22	%	ASTM D395B
Additional Information	Nominal Value		
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			
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

NOTE

- | | |
|----|------------------------|
| 1. | Mouth die C, 510mm/min |
| 2. | Mouth die C, 510mm/min |
| 3. | C mold, 510mm/min |
| 4. | C mold, 510mm/min |
| 5. | C mold, 510mm/min |
| 6. | Mouth die C, 510mm/min |
| 7. | C mold, 510mm/min |
| 8. | Type 1 |

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