

Monprene® MP-1869

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® MP-1869 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.

Typical application areas include:

Handle
safety equipment
packing
kitchen utensils
engineering/industrial accessories

General Information			
Uses	Safety equipment		
	Handle		
	Packaging		
	Kitchen utensils		
	Washer		
	Pipe fittings		
	Sporting goods		
	Shell		
	Stationery		
	Consumer goods application field		
	Toothbrush handle		
	Medical/nursing supplies		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.878	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (150°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	12		ASTM D2240
Shaw OO	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	0.552	MPa	ASTM D412

Tensile Strength (Break)	3.45	MPa	ASTM D412
Tensile Elongation (Break)	700	%	ASTM D412
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

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