

Monprene® CP-38138 XRD1 (PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:
Monprene CP-38138 XRD1 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-33138 XRD1 is a low density, low hardness grade that exhibits excellent elastic characteristics. This grade is suitable for both injection molding and extrusion.

General Information			
Features	Low Specific Gravity		
	Without Fillers		
	Low density		
	High elasticity		
	Medium liquidity		
	Good chemical resistance		
	Lubrication		
	Extended tensile rate		
	Hardness, low		
Uses	Safety equipment		
	Handle		
	Films		
	Washer		
	Rubber substitution		
	Consumer goods application field		
	Knob		
RoHS Compliance	RoHS compliance		
Appearance	Available colors		
	Clear/transparent		
	Natural color		
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) (190°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	40		ASTM D2240
Shaw A, 5 seconds	38		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
Transverse flow: 100% strain	0.296	MPa	ASTM D412
Flow: 100% strain	1.73	MPa	ASTM D412
Transverse flow: 300% strain	0.476	MPa	ASTM D412
Flow: 300% strain	1.97	MPa	ASTM D412
Tensile Strength ²			ASTM D412
Transverse flow: Fracture	10.2	MPa	ASTM D412
Flow: Fracture	7.32	MPa	ASTM D412
Tensile Elongation ³			ASTM D412
Transverse flow: Fracture	> 1000	%	ASTM D412
Flow: Fracture	> 1000	%	ASTM D412
Tear Strength ⁴			ASTM D624
Transverse flow	33.6	kN/m	ASTM D624
Flow	36.6	kN/m	ASTM D624
Compression Set ⁵ (23°C, 22 hr)	11	%	ASTM D395B
Legal statement			

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Injection	Nominal Value	Unit
Rear Temperature	188 - 227	°C
Middle Temperature	188 - 227	°C
Front Temperature	188 - 227	°C
Nozzle Temperature	188 - 227	°C
Processing (Melt) Temp	188 - 227	°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		

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.	177 - 216	°C
Cylinder Zone 2 Temp.	177 - 216	°C
Cylinder Zone 3 Temp.	177 - 216	°C
Cylinder Zone 4 Temp.	177 - 216	°C
Cylinder Zone 5 Temp.	177 - 216	°C
Die Temperature	177 - 216	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE

- | | |
|----|-------------------|
| 1. | C mold, 510mm/min |
| 2. | C mold, 510mm/min |
| 3. | C mold, 510mm/min |
| 4. | C mold, 510mm/min |
| 5. | Type 1 |

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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