

Monprene® MP-2104

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene MP-2104 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene MP-2104 is a low hardness, opaque grade that exhibits excellent mold release, suitable for injection molding and extrusion.

General Information			
Features	High elasticity		
	Good liquidity		
	Good flexibility		
	Good tear strength		
	Good coloring		
	Good demoulding performance		
Uses	Safety equipment		
	Handle		
	Soft handle		
	Sporting goods		
	Stationery		
	Consumer goods application field		
Toothbrush handle			
RoHS Compliance	RoHS compliance		
Appearance	Opacity		
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)			ASTM D1238
190°C/2.16 kg	1.5	g/10 min	ASTM D1238
200°C/5.0 kg	18	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	30		ASTM D2240
Shaw A, 5 seconds	28		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412

100% strain	0.689	MPa	ASTM D412
300% strain	1.34	MPa	ASTM D412
Tensile Strength (Break)	6.48	MPa	ASTM D412
Tensile Elongation (Break)	820	%	ASTM D412
Tear Strength - Flow ¹	22.6	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	12	%	ASTM D395

Legal statement

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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	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.	182 - 232	°C
Cylinder Zone 2 Temp.	188 - 238	°C
Cylinder Zone 3 Temp.	193 - 243	°C
Cylinder Zone 4 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. C mould

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