

Monprene® CP-29048 CLR

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-29048 CLR is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-29048 CLR is a transparent grade suitable for injection molding and extrusion.

General Information	
Features	Low Specific Gravity
	Low density
	smoothness
	Medium liquidity
	Medium hardness
Uses	Safety equipment
	Handle
	Kitchen utensils
	Washer
	Pipe fittings
	Sporting goods
	Stationery
	Consumer goods application field
	Toothbrush handle
Appearance	Clear/transparent
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	50		ASTM D2240
Shore A, 5 seconds, injection molding	48		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	1.17	MPa	ASTM D412
Flow: 100% strain ²	2.06	MPa	ASTM D412
Transverse flow: 300% strain ³	2.52	MPa	ASTM D412

Flow: 300% strain ⁴	3.74	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	11.8	MPa	ASTM D412
Flow: Fracture	9.20	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	630	%	ASTM D412
Flow: Fracture	660	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	41.7	kN/m	ASTM D624
Flow	37.1	kN/m	ASTM D624
Compression Set ⁸ (23°C, 22 hr)	16	%	ASTM D395B

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

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

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

Screw Speed: 30 to 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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