

Monprene® CP-38225 XRD2 (PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:
Monprene CP-38225 XRD2 is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-38225 XRD2 is a low hardness, low density, clear grade that is suitable for both injection molding and extrusion.

General Information			
Features	Low Specific Gravity		
	Without Fillers		
	Low density		
	smoothness		
	Workability, good		
	Good adhesion		
	Medium liquidity		
	Good chemical resistance		
	Lubrication		
	Hardness, low		
Uses	Handle		
	Washer		
	Sporting goods		
	Stationery		
	Rubber substitution		
	Consumer goods application field		
	Knob		
RoHS Compliance	RoHS compliance		
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) (190°C/2.16 kg)	13	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method

Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	28		ASTM D2240
Shore A, 5 seconds, injection molding	25		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
Transverse flow: 100% strain	0.600	MPa	ASTM D412
Flow: 100% strain	0.731	MPa	ASTM D412
Transverse flow: 300% strain	1.34	MPa	ASTM D412
Flow: 300% strain	1.81	MPa	ASTM D412
Tensile Strength ²			ASTM D412
Transverse flow: Fracture	7.05	MPa	ASTM D412
Flow: Fracture	6.90	MPa	ASTM D412
Tensile Elongation ³			ASTM D412
Transverse flow: Fracture	560	%	ASTM D412
Flow: Fracture	520	%	ASTM D412
Tear Strength ⁴			ASTM D624
Transverse flow	23.3	kN/m	ASTM D624
Flow	21.2	kN/m	ASTM D624
Compression Set ⁵ (23°C, 22 hr)	19	%	ASTM D395B
Legal statement			

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Injection	Nominal Value	Unit
Rear Temperature	171 - 204	°C
Middle Temperature	171 - 204	°C
Front Temperature	171 - 204	°C
Nozzle Temperature	171 - 204	°C
Processing (Melt) Temp	171 - 204	°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

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.	160 - 193	°C

Cylinder Zone 2 Temp.	160 - 193	°C
Cylinder Zone 3 Temp.	160 - 193	°C
Cylinder Zone 4 Temp.	160 - 193	°C
Cylinder Zone 5 Temp.	160 - 193	°C
Die Temperature	160 - 193	°C

Extrusion instructions

Screw Speed: 30 to 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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