

Monprene® CP-18216 CLR

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-18216 CLR is a clear thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-18216 CLR is a low hardness, low specific gravity grade that exhibits high flow characteristics, suitable for injection molding and extrusion.

General Information			
Features	Low Specific Gravity Without Fillers Low density smoothness High liquidity Lubrication Hardness, low		
Uses	Handle Kitchen utensils Stationery Consumer goods application field Toothbrush handle		
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)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	20		ASTM D2240
Shore A, 5 seconds, injection molding	16		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	0.400	MPa	ASTM D412
Flow: 100% strain ²	0.400	MPa	ASTM D412
Transverse flow: 300% strain ³	0.765	MPa	ASTM D412
Flow: 300% strain ⁴	0.786	MPa	ASTM D412

Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	5.00	MPa	ASTM D412
Flow: Fracture	4.91	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	560	%	ASTM D412
Flow: Fracture	600	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	10.3	kN/m	ASTM D624
Flow	10.5	kN/m	ASTM D624
Compression Set ⁸ (23°C, 22 hr)	31	%	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

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

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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