

Monprene® CP-13022D

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-13022D is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-13022D is a high hardness grade that exhibits good abrasion resistance and is suitable for injection molding.

General Information	
Features	Low Specific Gravity
	Impact resistance, good
	Good formability
	Good wear resistance
Uses	Handle
	Packaging
	Kitchen utensils
	Washer
	Pipe fittings
	Stationery
	Consumer goods application field
	Toothbrush handle
Appearance	Translucent
Forms	Particle
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)	12	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	90		ASTM D2240
Shaw A, 5 seconds	88		ASTM D2240
Shaw D, 5 seconds	35		ASTM D2240
Shaw D, 10 seconds	30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	4.14	MPa	ASTM D412
300% strain	4.83	MPa	ASTM D412

Tensile Strength (Break)	7.86	MPa	ASTM D412
Tensile Elongation (Break)	730	%	ASTM D412
Tear Strength - Flow (21°C)	48.2	kN/m	ASTM D624
Compression Set (23°C)	30	%	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	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

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