Monprene® OM-10275

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene®OM-10275 is a thermoplastic elastomer (TPE) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is extrusion or injection molding. Monprene®The main characteristics of the OM-10275 are: resistance to sunlight.
Typical application areas include:
Handle
engineering/industrial accessories
Electrical/electronic applications
electrical appliances
Tools

General Information	
Features	Sunlight Resistant
	Without Fillers
	smoothness
	Light stabilization
	Medium liquidity
	Lubrication
	Medium density
	Medium hardness
	UV absorption
Uses	Handle
	overmolding
	Electrical appliances
	Power/other tools
	Soft handle
	Mobile phone
	Sporting goods
	Stationery
	Knob
	Dental application field
	Toothbrush handle
	Bonding
Appearance	Opacity
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.998	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	65		ASTM D2240
Shore A, 1 second, injection molding [1]	78		ASTM D2240
Shore A, 5 seconds, injection molding [2]	75		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress			ASTM D412
Transverse flow: 100% strain [3]	3.12	MPa	ASTM D412
Flow: 100% strain [4]	4.78	MPa	ASTM D412
Transverse flow: 300% strain [5]	5.05	MPa	ASTM D412
Flow: 300% strain [6]	6.47	MPa	ASTM D412
Tensile Strength [7]			ASTM D412
Transverse flow: Fracture	8.20	MPa	ASTM D412
Flow: Fracture	9.88	MPa	ASTM D412
Tensile Elongation [8]			ASTM D412
Transverse flow: Fracture	580	%	ASTM D412
Flow: Fracture	660	%	ASTM D412
Tear Strength [9]			ASTM D624
Transverse flow	45.9	kN/m	ASTM D624
Flow	53.1	kN/m	ASTM D624
Compression Set [10]			ASTM D395B
23°C, 22 hr	47	%	ASTM D395B
70°C, 22 hr	90	%	ASTM D395B
Additional Information	**Nominal Value**		
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			
Injection	**Nominal Value**	**Unit**	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	138 - 160	°C	
Middle Temperature	182 - 199	°C	
Front Temperature	182 - 199	°C	
Nozzle Temperature	193 - 210	°C	
Processing (Melt) Temp	177 - 199	°C	
Mold Temperature	4.44 - 48.9	°C	
Injection Pressure	1.38 - 5.52	MPa	
Back Pressure	0.172 - 0.862	MPa	

Screw Speed	50 - 100	rpm
Cushion	3.81 - 25.4	mm

Injection instructions
潮湿会使材料降解.建议进行干燥处理.可以把材料放入除湿干燥机,在140°F的温度下干燥2-4小时.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	138 - 149	°C
Cylinder Zone 2 Temp.	149 - 160	°C
Cylinder Zone 3 Temp.	160 - 182	°C
Cylinder Zone 5 Temp.	171 - 193	°C
Die Temperature	182 - 204	°C

NOTE	
1.	Aging 48 hr
2.	Aging 48 hr
3.	Mouth die C, 510mm/min
4.	Mouth die C, 510mm/min
5.	C mold, 510mm/min
6.	C mold, 510mm/min
7.	C mold, 510mm/min
8.	Mouth die C, 510mm/min
9.	C mold, 510mm/min
10.	Type 1

Recommended distributors for this material

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