

Monprene® PR-13247

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene PR-13247 NAT is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene PR-13247 NAT is a medium hardness grade suitable for injection molding and extrusion.

General Information	
Features	Low Specific Gravity Low density smoothness Low liquidity Lubrication Medium hardness
Uses	Safety equipment Handle Kitchen utensils Washer Sporting goods Stationery Consumer goods application field Toothbrush handle
Appearance	Translucent
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	1.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	48		ASTM D2240
Shore A, 5 seconds, injection molding	47		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	1.52	MPa	ASTM D412
Flow: 100% strain ²	2.00	MPa	ASTM D412

Transverse flow: 300% strain ³	3.03	MPa	ASTM D412
Flow: 300% strain ⁴	3.65	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	8.48	MPa	ASTM D412
Flow: Fracture	5.86	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	680	%	ASTM D412
Flow: Fracture	610	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	35.0	kN/m	ASTM D624
Flow	31.5	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			
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		

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