

Monprene® CP-28964

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-28964 is a clear high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-28964 is a medium hardness grade that exhibits excellent sunlight resistance and UV absorbing characteristics, suitable for injection molding and extrusion.

| General Information | | | |
|--|----------------------------------|----------|-------------|
| Features | Low Specific Gravity | | |
| | Sunlight Resistant | | |
| | Without Fillers | | |
| | Low density | | |
| | smoothness | | |
| | Light stabilization | | |
| | Medium liquidity | | |
| | Lubrication | | |
| | Medium hardness | | |
| | UV absorption | | |
| Uses | Safety equipment | | |
| | Handle | | |
| | Kitchen utensils | | |
| | Washer | | |
| | Pipe fittings | | |
| | Sporting goods | | |
| | Stationery | | |
| | Consumer goods application field | | |
| RoHS Compliance | RoHS compliance | | |
| Appearance | Clear/transparent | | |
| Forms | Particle | | |
| Processing Method | Extrusion | | |
| | Injection molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 0.888 | g/cm³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (200°C/5.0 kg) | 14 | g/10 min | ASTM D1238 |
| Hardness | Nominal Value | Unit | Test Method |
| Durometer Hardness | | | ASTM D2240 |
| Shore A, 1 second, injection molding | 70 | | ASTM D2240 |

| Shore A, 5 seconds, injection molding | 67 | | ASTM D2240 |
|---------------------------------------|---------------|------|-------------|
| Elastomers | Nominal Value | Unit | Test Method |
| Tensile Stress ¹ | | | ASTM D412 |
| Transverse flow: 100% strain | 2.53 | MPa | ASTM D412 |
| Flow: 100% strain | 3.85 | MPa | ASTM D412 |
| Transverse flow: 300% strain | 3.52 | MPa | ASTM D412 |
| Flow: 300% strain | 4.76 | MPa | ASTM D412 |
| Tensile Strength ² | | | ASTM D412 |
| Transverse flow: Fracture | 13.6 | MPa | ASTM D412 |
| Flow: Fracture | 5.10 | MPa | ASTM D412 |
| Tensile Elongation ³ | | | ASTM D412 |
| Transverse flow: Fracture | 780 | % | ASTM D412 |
| Flow: Fracture | 390 | % | ASTM D412 |
| Tear Strength ⁴ | | | ASTM D624 |
| Transverse flow | 39.4 | kN/m | ASTM D624 |
| Flow | 34.5 | kN/m | ASTM D624 |
| Compression Set ⁵ | | | ASTM D395B |
| 23°C, 22 hr | 25 | % | ASTM D395B |
| 70°C, 22 hr | 46 | % | ASTM D395B |
| 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 - 49 | °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. | 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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