

Monprene® MP-3955B

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® MP-3955B 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.

Typical application areas include:

- Handle
- safety equipment
- packing
- kitchen utensils
- engineering/industrial accessories

General Information			
Uses	Safety equipment		
	Handle		
	Packaging		
	Kitchen utensils		
	Washer		
	Pipe fittings		
	Sporting goods		
	Shell		
	Stationery		
	Consumer goods application field		
	Toothbrush handle		
	Medical/nursing supplies		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	32	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	81		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	10.0	MPa	ASTM D412
Tensile Elongation (Break)	650	%	ASTM D412
Tear Strength	38.5	kN/m	ASTM D624
Compression Set			ASTM D395

23°C, 22 hr	35	%	ASTM D395
70°C, 22 hr	57	%	ASTM D395
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746
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

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

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

Screw Speed: 30 to 100 rpm

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Recommended distributors for this material

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