

Monprene® IN-15074

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

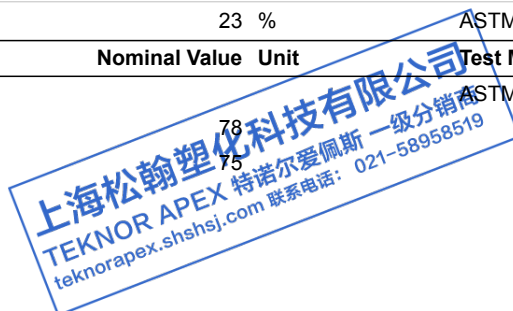
Monprene IN-15074 is a general purpose thermoplastic elastomer designed for the industrial market. Monprene IN-15074 is a medium hardness, low density grade that is suitable for injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Low Density • Low Flow	• Low Specific Gravity • Medium Hardness	• Without Fillers
Uses	• Consumer Applications • Gaskets	• Handles • Sporting Goods	• Wheels • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	4.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	576	psi	
Flow : 100% Strain	760	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	811	psi	
Flow : 300% Strain	1030	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	1910	psi	
Flow : Break	1640	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	700	%	
Flow : Break	590	%	
Tear Strength ²			ASTM D624
Across Flow	342	lbf/in	
Flow	323	lbf/in	
Compression Set ³ (73°F, 22 hr)	23	%	ASTM D395B
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	78		
Shore A, 5 sec, Injection Molded	75		



Revision Date: 8/18/2016

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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	360 to 450	°F
Middle Temperature	370 to 460	°F
Front Temperature	380 to 470	°F
Nozzle Temperature	390 to 480	°F
Processing (Melt) Temp	390 to 480	°F
Mold Temperature	95 to 120	°F
Injection Pressure	200 to 800	psi
Injection Rate		Fast
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Injection Notes

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.	360 to 450	°F
Cylinder Zone 2 Temp.	370 to 460	°F
Cylinder Zone 3 Temp.	380 to 470	°F
Cylinder Zone 4 Temp.	380 to 470	°F
Cylinder Zone 5 Temp.	390 to 480	°F
Die Temperature	390 to 480	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² Die C, 20 in/min

³ Type 1

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