

Monprene® IN-12985

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

Monprene IN-12985 is a high performance high hardness filled thermoplastic elastomer designed for a variety of applications in the industrial market. Monprene IN-12985 is UV absorbing, sunlight resistant, has good compression set and is suitable for injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • High Hardness • Light Stabilized	• Low Density • Low Flow • Low Specific Gravity	• Sunlight Resistant • UV Absorbing
Uses	• Gaskets • Handles	• Industrial Applications • Tubing	
RoHS Compliance	• RoHS Compliant		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.940		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	15	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	635	psi	
Flow : 100% Strain	771	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	804	psi	
Flow : 300% Strain	977	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	3220	psi	
Flow : Break	2210	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	850	%	
Flow : Break	700	%	
Tear Strength ²			ASTM D624
Across Flow	349	lbf/in	
Flow	341	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	34	%	
158°F, 22 hr	57	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	89		
Shore A, 5 sec, Injection Molded	85		

上海松塑塑化科技有限公司
 TEKNOR APEX 特诺尔爱佩斯 一级分销商
 teknorapex.shshs.com 联系电话: 021-58958519

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Legal Statement

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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.	390 to 480	°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

Teknor Apex Company Corporate Headquarters

In U.S. for Vinyls, TPEs, Colorants,
Engineered Thermoplastics (Chem Polymer)
505 Central Avenue
Pawtucket, Rhode Island 02861 U.S.

Phone: 401-725-8000
Fax: 401-725-8095
Toll Free (U.S. only) 800-556-3864

info@teknorapex.com

Teknor Apex U.K. Ltd.

Tat Bank Road
Oldbury, West Midlands B69 4NH England

Phone: (44) 121-665-2100
Fax: (44) 121-544-5530

etpsales@teknorapex.co.uk



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