Monprene® CP-18143 CLR

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

Monprene CP-18143 CLR is a clear thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-18143 CLR is a low hardness, low density, high flow grade suitable for both injection molding and extrusion.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Flow • Low Density • Low Hardness	• Low Specific Gravity • Lubricated • Slip	• Without Fillers
Uses	• Consumer Applications • Gaskets • Handles	• Kitchenware • Sporting Goods • Toothbrush Handles	• Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.880		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	25	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	1060	psi	
Flow : 100% Strain	859	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	276	psi	
Flow : 300% Strain	335	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	942	psi	
Flow : Break	1030	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	590	%	
Flow : Break	690	%	
Tear Strength [2]			ASTM D624
Across Flow	132	lbf/in	
Flow	138	lbf/in	
Compression Set [3] (73°F, 22 hr)	16	%	ASTM D395B
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	42		
Shore A, 5 sec, Injection Molded	40		

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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

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