Monprene® CP-28964

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

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			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Light Stabilized • Low Density • Low Specific Gravity • Lubricated	• Medium Flow • Medium Hardness • Slip • Sunlight Resistant	• UV Absorbing • Without Fillers
Uses	• Consumer Applications • Gaskets • Handles	• Kitchenware • Safety Equipment • Sporting Goods	• Tubing • 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	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	14	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	367	psi	
Flow : 100% Strain	559	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	511	psi	
Flow : 300% Strain	690	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	1970	psi	
Flow : Break	740	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	780	%	
Flow : Break	390	%	
Tear Strength [2]			ASTM D624
Across Flow	225	lbf/in	
Flow	197	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	25	%	
158°F, 22 hr	46	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	70		
Shore A, 5 sec, Injection Molded	67		

Revision Date: 12/2/2016

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Legal Statement

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 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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