

Monprene® RG-19221 NAT

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

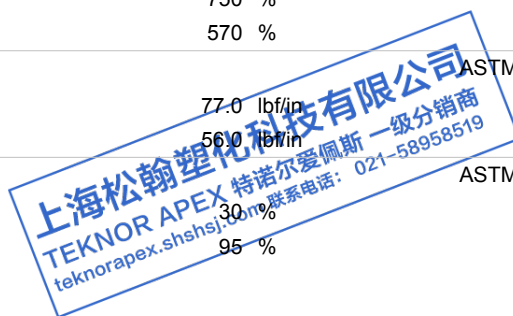
Monprene RG-19221 is a high performance thermoplastic elastomer designed for regulated applications including food contact. Monprene RG-19221 is a low hardness, low density, high flow, unfilled grade with excellent adhesion to PP and complies with various US FDA regulations for food contact. This grade is suitable for injection molding. Please contact Teknor Apex for a regulatory compliance letter.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Moldability • Good Processability • High Flow	• Low Density • Low Hardness • Low Specific Gravity	• Slip • Soft • Without Fillers
Uses	• Consumer Applications • Gaskets • Handles • Kitchenware	• Packaging • Safety Equipment • Sporting Goods • Toothbrush Handles	• Tubing • Writing Instruments
Agency Ratings	• FDA Food Contact, Unspecified Rating		
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (175°C/2.16 kg)	60	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	74.0	psi	
Flow : 100% Strain	121	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	149	psi	
Flow : 300% Strain	205	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	470	psi	
Flow : Break	281	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	750	%	
Flow : Break	570	%	
Tear Strength ²			ASTM D624
Across Flow	77.0	lbf/in	
Flow	56.0	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	30	%	
158°F, 22 hr	95	%	



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Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	22		
Shore A, 5 sec, Injection Molded	21		

Legal Statement

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchaser assumes all risks and liability for the results of use of the products, including use in accordance with seller's recommendations. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or others. There is no warranty of merchantability and there are no other warranties for the products described. For detailed Product Stewardship information, please contact us. Any product of Teknor Apex, including product names, shall not be used or tested in medical or food contact applications without the prior written acknowledgement of Teknor Apex as to the intended use. Please note that some products may not be available in one or more countries.

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	320 to 410	°F
Middle Temperature	330 to 420	°F
Front Temperature	340 to 430	°F
Nozzle Temperature	350 to 440	°F
Processing (Melt) Temp	350 to 440	°F
Mold Temperature	60 to 100	°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 2



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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

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

info@teknorapex.com

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

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