

# Monprene® CP-15140D-10 NAT XRD1

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

## General Information

### General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Closures • Consumer Applications • Gaskets • Handles	• Kitchenware • Medical/Healthcare Applications • Packaging • Safety Equipment	• Sporting Goods • Toothbrush Handles • Tubing • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/21.6 kg)	4.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	1880	psi	ASTM D412
Tensile Strength (Break)	3900	psi	ASTM D412
Tensile Elongation (Break)	580	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore D	40		
Shore D, 5 sec	38		

## 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

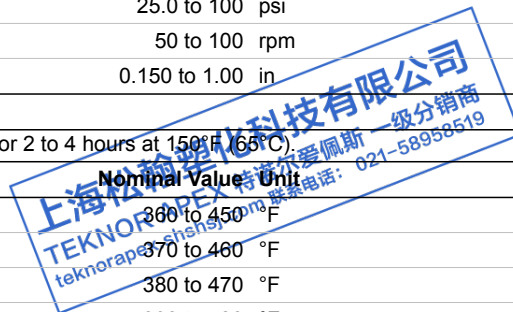
Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

### 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

Revision Date: 6/1/2016

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### Extrusion Notes

Screw Speed: 30 to 100 rpm

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

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