

Monprene® CP-28128 X4 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

General Information

Product Description

Monprene CP-28128 X4 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-28128 X4 is a low hardness, low density grade that exhibits excellent melt strength and flexibility characteristics. This grade is suitable for both injection molding and extrusion.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Good Adhesion • Good Colorability • Good Flexibility • Good Melt Strength • Good Moldability	• Good Processability • Good Tear Strength • Good Toughness • Halogen Free • High Elongation • High Tensile Strength	• Low Compression Set • Low Density • Low Flow • Low Hardness • Resilient
Uses	• Flexible Grips • Foam • Gaskets • General Purpose	• Handles • Hose • Knobs • Profiles	• Rubber Replacement • Seals • Tubing • Windows & Doors
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Cast Film	• Extrusion	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.880		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.5	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Flow ² (100% Strain)	90.0	psi	ASTM D412
Tensile Stress - Flow ² (300% Strain)	170	psi	ASTM D412
Tensile Strength - Flow ² (Break)	1460	psi	ASTM D412
Tensile Elongation - Flow ² (Break)	860	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	30		
Shore A, 5 sec, Injection Molded	28		

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	340 to 440	°F

Revision Date: 6/1/2016

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Injection	Nominal Value	Unit
Middle Temperature	340 to 440	°F
Front Temperature	340 to 440	°F
Nozzle Temperature	340 to 440	°F
Processing (Melt) Temp	340 to 440	°F
Mold Temperature	60 to 90	°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.	340 to 440	°F
Cylinder Zone 2 Temp.	340 to 440	°F
Cylinder Zone 3 Temp.	340 to 440	°F
Cylinder Zone 4 Temp.	340 to 440	°F
Cylinder Zone 5 Temp.	340 to 440	°F
Die Temperature	340 to 440	°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

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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