

Monprene® CP-28128 X4 (PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:
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 Information	
Features	Low compressive deformability
	Low density
	High tensile strength
	Workability, good
	Good formability
	Good melt strength
	Good flexibility
	Good tear strength
	Good coloring
	Good adhesion
	Low liquidity
	Good chemical resistance
	Good toughness
	Halogen-free
	Extended tensile rate
	Hardness, low
	Elastic
Uses	Handle
	Washer
	Pipe
	Pipe fittings
	Doors and Windows
	Seals
	Foam
	Soft handle
	General
	Rubber substitution
	Profile

Knob

RoHS Compliance	RoHS compliance
Appearance	Available colors Clear/transparent Natural color
Forms	Particle
Processing Method	Extrusion cast film Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.878	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.5	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	30		ASTM D2240
Shore A, 5 seconds, injection molding	28		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Flow ¹			ASTM D412
100% strain	0.621	MPa	ASTM D412
300% strain	1.17	MPa	ASTM D412
Tensile Strength - Flow ² (Break)	10.1	MPa	ASTM D412
Tensile Elongation - Flow ³ (Break)	860	%	ASTM D412

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.

Injection	Nominal Value	Unit
Rear Temperature	171 - 227	°C
Middle Temperature	171 - 227	°C
Front Temperature	171 - 227	°C
Nozzle Temperature	171 - 227	°C
Processing (Melt) Temp	171 - 227	°C
Mold Temperature	16 - 32	°C
Injection Pressure	1.38 - 5.52	MPa
Injection Rate	Fast	
Back Pressure	0.172 - 0.689	MPa

Screw Speed	50 - 100	rpm
Cushion	3.81 - 25.4	mm

Injection instructions

无需干燥.但如果湿度过大,则将粒料在150°F (65°C)的温度下干燥2-4小时.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	171 - 227	°C
Cylinder Zone 2 Temp.	171 - 227	°C
Cylinder Zone 3 Temp.	171 - 227	°C
Cylinder Zone 4 Temp.	171 - 227	°C
Cylinder Zone 5 Temp.	171 - 227	°C
Die Temperature	171 - 227	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE

1.	C mold, 510mm/min
2.	C mold, 510mm/min
3.	C mold, 510mm/min

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