

Monprene® CP-22147

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-22147 is a clear thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-22147 is an ozone resistant grade that exhibits excellent good abrasion resistance and is suitable for injection molding and extrusion.

General Information	
Features	Flexibility at low temperatures
	Good tear strength
	Good wear resistance
	Ozone resistance
	Good weather resistance
Uses	Safety equipment
	Handle
	Packaging
	Kitchen utensils
	Washer
	Sporting goods
	Stationery
	Consumer goods application field
	Toothbrush handle
Appearance	Clear/transparent
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.5	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	52		ASTM D2240
Shaw A, 5 seconds	50		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	1.83	MPa	ASTM D412
200% strain	2.83	MPa	ASTM D412

300% strain	4.14	MPa	ASTM D412
Tensile Strength (Break)	13.8	MPa	ASTM D412
Tensile Elongation (Break)	640	%	ASTM D412
Tear Strength ¹	43.8	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	13	%	ASTM D395

Injection	Nominal Value	Unit
Rear Temperature	182 - 232	°C
Middle Temperature	188 - 238	°C
Front Temperature	193 - 243	°C
Nozzle Temperature	199 - 249	°C
Processing (Melt) Temp	199 - 249	°C
Mold Temperature	35.0 - 48.9	°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.	182 - 232	°C
Cylinder Zone 2 Temp.	188 - 238	°C
Cylinder Zone 3 Temp.	193 - 243	°C
Cylinder Zone 5 Temp.	199 - 249	°C
Die Temperature	199 - 249	°C

Extrusion instructions

螺杆转速30 - 100 rpm

NOTE

1. C mould

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