

Monprene® OM-10220

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-10220 is a thermoplastic elastomer (TPE) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is extrusion or injection molding.

Typical application areas include:

Handle
engineering/industrial accessories
Electrical/electronic applications
electrical appliances
Tools

General Information			
Uses	Handle		
	overmolding		
	Electrical appliances		
	Power/other tools		
	Soft handle		
	Mobile phone		
	Sporting goods		
	Stationery		
	Knob		
	Dental application field		
	Toothbrush handle		
	Bonding		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.938	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	20		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	1.38	MPa	ASTM D412
Tensile Strength (Break)	3.10	MPa	ASTM D412
Tensile Elongation (Break)	550	%	ASTM D412
Additional Information	Nominal Value		

Adhesion to ABS

Adhesion to PC

Adhesion to PC/ABS

Injection	Nominal Value	Unit
Drying Temperature	60.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	138 - 188	°C
Middle Temperature	154 - 199	°C
Front Temperature	154 - 216	°C
Nozzle Temperature	154 - 221	°C
Processing (Melt) Temp	177 - 199	°C
Mold Temperature	10.0 - 32.2	°C
Injection Pressure	1.38 - 5.52	MPa
Back Pressure	0.172 - 0.862	MPa
Screw Speed	50 - 100	rpm
Cushion	3.81 - 25.4	mm

Injection instructions

潮湿会使材料降解.建议进行干燥处理.可以把材料放入除湿干燥机,在140°F的温度下干燥2-4小时.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	138 - 149	°C
Cylinder Zone 2 Temp.	149 - 160	°C
Cylinder Zone 3 Temp.	160 - 182	°C
Cylinder Zone 5 Temp.	171 - 193	°C
Die Temperature	182 - 204	°C

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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