

Monprene® CP-19129

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene CP-19129 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-19129 is a low hardness TPE that exhibits excellent slip characteristics, suitable for injection molding and extrusion.

General Information	
Additive	Optical Brightener and Blueing Agent
Features	Low Specific Gravity
	Without Fillers
	Low density
	smoothness
	Ablation resistance
	Lubrication
	ablation
Uses	Hardness, low
	Handle
	Washer
	Stationery
Appearance	Consumer goods application field
	Clear/transparent
	Particle
Forms	Extrusion
Processing Method	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
Shore A, 1 second, injection molding	32		ASTM D2240
Shore A, 5 seconds, injection molding	29		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.36	MPa	ASTM D412
Flow: 100% strain ²	2.12	MPa	ASTM D412
Transverse flow: 300% strain ³	2.68	MPa	ASTM D412

Flow: 300% strain ⁴	2.47	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	8.94	MPa	ASTM D412
Flow: Fracture	7.09	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	1300	%	ASTM D412
Flow: Fracture	1400	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	27.8	kN/m	ASTM D624
Flow	21.4	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	8.4	%	ASTM D395B
70°C, 22 hr	55	%	ASTM D395B
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			
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.	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			
Screw Speed: 30 to 100 rpm			
NOTE			
1.	Mouth die C, 510mm/min		
2.	Mouth die C, 510mm/min		
3.	C mold, 510mm/min		
4.	C mold, 510mm/min		
5.	C mold, 510mm/min		
6.	Mouth die C, 510mm/min		

7.	C mold, 510mm/min
8.	Type 1

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