

Monprene® OM-10240

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-10240 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.

Monprene® The main features of the OM-10240 are:

- low hardness
- daylight resistance

Typical application areas include:

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

General Information	
Features	Sunlight Resistant
	Without Fillers
	smoothness
	Light stabilization
	Low liquidity
	Lubrication
	Hardness, low
	Medium density
	UV absorption
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	0.978	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	35		ASTM D2240
Shore A, 1 second, injection molding ¹	43		ASTM D2240
Shore A, 5 seconds, injection molding ²	40		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ³	1.48	MPa	ASTM D412
Flow: 100% strain ⁴	1.61	MPa	ASTM D412
Transverse flow: 300% strain ⁵	3.16	MPa	ASTM D412
Flow: 300% strain ⁶	3.41	MPa	ASTM D412
Tensile Strength ⁷			ASTM D412
Transverse flow: Fracture	5.18	MPa	ASTM D412
Flow: Fracture	4.83	MPa	ASTM D412
Tensile Elongation ⁸			ASTM D412
Transverse flow: Fracture	470	%	ASTM D412
Flow: Fracture	450	%	ASTM D412
Tear Strength ⁹			ASTM D624
Transverse flow	21.9	kN/m	ASTM D624
Flow	21.4	kN/m	ASTM D624
Compression Set ¹⁰			ASTM D395B
23°C, 22 hr	39	%	ASTM D395B
70°C, 22 hr	80	%	ASTM D395B
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 - 160	°C	
Middle Temperature	182 - 199	°C	
Front Temperature	182 - 199	°C	
Nozzle Temperature	193 - 210	°C	
Processing (Melt) Temp	177 - 199	°C	
Mold Temperature	4.44 - 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

NOTE

1. Aging 48 hr
2. Aging 48 hr
3. Mouth die C, 510mm/min
4. Mouth die C, 510mm/min
5. C mold, 510mm/min
6. C mold, 510mm/min
7. C mold, 510mm/min
8. Mouth die C, 510mm/min
9. C mold, 510mm/min
10. Type 1

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