

Monprene® IN-12990

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® IN-12990 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 IN-12990 are:

high hardness

daylight resistance

Typical application areas include:

engineering/industrial accessories

industrial applications

outdoor applications

Hose

Handle

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Low density		
	Light stabilization		
	High hardness		
Uses	Handle		
	Washer		
	Industrial application		
	Pipe fittings		
	Outdoor application		
Processing Method	Sporting goods		
	Clear/transparent		
	Particle		
	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
Molding Shrinkage			ASTM D955
Flow	1.6	%	ASTM D955
Transverse flow	1.7	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240

Shore A, 1 second, injection molding	92		ASTM D2240
Shore A, 5 seconds, injection molding	90		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	138	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	7.58	MPa	ASTM D412
Tensile Strength (Break)	17.2	MPa	ASTM D412
Tensile Elongation (Break)	700	%	ASTM D412
Compression Set (23°C, 22 hr)	15	%	ASTM D395
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	65.0	°C	ASTM D1525
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			

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