

# Monprene® CP-18250 (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

The Monprene CP-18200 Unfilled, High Flow Series of thermoplastic elastomer compounds, with good UV resistance, available in NAT or colors, from 40 to 80 Shore A, are designed specifically for EU consumer product applications requiring a soft, rubber-like feel. Monprene CP-18250 is a medium hardness, low density grade that is suitable for injection molding.

| General Information |                                  |
|---------------------|----------------------------------|
| Features            | Low Specific Gravity             |
|                     | Without Fillers                  |
|                     | Low density                      |
|                     | Good UV resistance               |
|                     | Good formability                 |
|                     | Good liquidity                   |
|                     | Good flexibility                 |
|                     | Good coloring                    |
|                     | Good adhesion                    |
|                     | Good chemical resistance         |
|                     | Good toughness                   |
|                     | Medium hardness                  |
|                     |                                  |
| Uses                | Handle                           |
|                     | overmolding                      |
|                     | Plug                             |
|                     | Bushing                          |
|                     | Washer                           |
|                     | Washer                           |
|                     | Leather case                     |
|                     | Soft touch application           |
|                     | Soft handle                      |
|                     | General                          |
|                     | Rubber substitution              |
|                     | Consumer goods application field |
|                     | Knob                             |
|                     |                                  |
| RoHS Compliance     | RoHS compliance                  |
| Appearance          | Translucent                      |
|                     | Available colors                 |
|                     |                                  |
| Forms               | Particle                         |

| Processing Method                                  | Injection molding |                   |             |
|--|-------------------|-------------------|-------------|
| Physical   | Nominal Value     | Unit              | Test Method |
| Density  | 0.890             | g/cm <sup>3</sup> | ISO 1183    |
| Hardness   | Nominal Value     | Unit              | Test Method |
| Durometer Hardness (Shore A, 5 sec)                | 50                |                   | ISO 868     |
| Elastomers   | Nominal Value     | Unit              | Test Method |
| Tensile Stress                                     |                   |                   | ISO 37      |
| 100% strain  | 1.40              | MPa               | ISO 37      |
| 300% strain  | 2.00              | MPa               | ISO 37      |
| Tensile Strength (Break)                           | 7.50              | MPa               | ISO 37      |
| Tensile Elongation (Break)                         | 800               | %                 | ISO 37      |
| Compression Set                                    |                   |                   | ISO 815     |
| 23°C, 22 hr  | 24                | %                 | ISO 815     |
| 70°C, 22 hr  | 44                | %                 | ISO 815     |
| Fill Analysis                                      | Nominal Value     | Unit              | Test Method |
| Apparent Viscosity (200°C, 206 sec <sup>-1</sup> ) | 99.0              | Pa · s            | ISO 11443   |

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| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Rear Temperature       | 120 - 160     | °C   |
| Middle Temperature     | 160 - 230     | °C   |
| Front Temperature      | 180 - 230     | °C   |
| Nozzle Temperature     | 180 - 230     | °C   |
| Processing (Melt) Temp | 180 - 230     | °C   |
| Mold Temperature       | 15 - 50       | °C   |
| Injection Rate         | Fast          |      |
| Back Pressure          | 0.500 - 1.50  | MPa  |
| Screw Speed            | 50 - 100      | rpm  |
| Cushion                | 3.00 - 25.0   | mm   |

#### Injection instructions

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 65°C (150°F). Low holding pressure is recommended

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Recommended distributors for this material

**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

