

Monprene® RG-55482 X (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene RG-55482 X is a high performance thermoplastic elastomer, available in NAT and colors, specifically designed for regulated applications including food contact packaging products. Monprene RG-55482 X is a high hardness, low density grade with excellent organoleptic properties and is suitable for injection molding and extrusion. Monprene RG-55482 X complies with various US FDA and European regulations and directives for food contact. Please contact Teknor Apex for a regulatory compliance letter.

General Information	
Features	<div>Low compressive deformability</div> <div>Low density</div> <div>Workability, good</div> <div>Adhesiveness</div> <div>Good sensory characteristics</div> <div>Good melt strength</div> <div>Good coloring</div> <div>Good adhesion</div> <div>Compliance of Food Exposure</div> <div>Halogen-free</div> <div>High hardness</div>
Uses	<div>Cookware Handles</div> <div>overmolding</div> <div>Cup</div> <div>Kitchen utensils</div> <div>Washer</div> <div>Non-specific food applications</div> <div>Cover</div> <div>Food packaging</div> <div>Food service sector</div> <div>Food container</div> <div>Shell</div> <div>Toys</div> <div>Consumer goods application field</div> <div>Liquid treatment</div>
Agency Ratings	<div>FDA Food Exposure, Not Rated</div> <div>European food contact, not rated</div>
RoHS Compliance	RoHS compliance

Appearance	Available colors Natural color
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.910	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness ¹			ASTM D2240
Shore A, 1 second, injection molding	84		ASTM D2240
Shore A, 5 seconds, injection molding	82		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	5.24	MPa	ASTM D412
Tensile Strength (Break)	7.45	MPa	ASTM D412
Tensile Elongation (Break)	360	%	ASTM D412
Tear Strength	45.5	kN/m	ASTM D624
Compression Set			ASTM D395B
23°C, 22 hr	28	%	ASTM D395B
70°C, 22 hr	73	%	ASTM D395B

Legal statement

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchaser assumes all risks and liability for the results of use of the products, including use in accordance with seller's recommendations. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or others. There is no warranty of merchantability and there are no other warranties for the products described. For detailed Product Stewardship information, please contact us. Any product of Teknor Apex, including product names, shall not be used or tested in medical or food contact applications without the prior written acknowledgement of Teknor Apex as to the intended use. Please note that some products may not be available in one or more countries.

Injection	Nominal Value	Unit
Rear Temperature	160 - 182	°C
Middle Temperature	166 - 188	°C
Front Temperature	171 - 193	°C
Nozzle Temperature	177 - 199	°C
Processing (Melt) Temp	177 - 199	°C
Mold Temperature	35 - 49	°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.	171 - 193	°C
Cylinder Zone 2 Temp.	177 - 196	°C
Cylinder Zone 3 Temp.	177 - 196	°C
Cylinder Zone 4 Temp.	182 - 199	°C
Cylinder Zone 5 Temp.	182 - 199	°C
Die Temperature	188 - 202	°C
Extrusion instructions		
螺杆转速30 - 100 rpm		
NOTE		
1.	TBD	

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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

