

Monprene® MP-1736T XRD (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene MP-1736T is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene MP-1736T is a low density, low hardness TPE that is suitable for injection molding and extrusion.

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Without Fillers		
	Low density		
	Light stabilization		
	High liquidity		
	Hardness, low		
	UV absorption		
Uses	Handle		
	Washer		
	Stationery		
	Consumer goods application field		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.878	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	45	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	23		ASTM D2240
Shore A, 5 seconds, injection molding	20		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	0.496	MPa	ASTM D412

Flow: 100% strain ²	0.807	MPa	ASTM D412
Transverse flow: 300% strain ³	0.979	MPa	ASTM D412
Flow: 300% strain ⁴	1.29	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	3.86	MPa	ASTM D412
Flow: Fracture	2.80	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Fracture	670	%	ASTM D412
Flow: Fracture	790	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	17.5	kN/m	ASTM D624
Flow	12.1	kN/m	ASTM D624
Compression Set ⁸ (23°C, 22 hr)	19	%	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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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

