

Monprene® CP-22442

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® CP-22442 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.

Typical application areas include:

safety equipment

engineering/industrial accessories

Consumer goods

Sporting goods

General Information			
Features	Low Specific Gravity		
	Low density		
	smoothness		
	Medium liquidity		
	Lubrication		
	Medium hardness		
Uses	Safety equipment		
	Washer		
	Sporting goods		
	Consumer goods application field		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.908	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.3	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	45		ASTM D2240
Shore A, 5 seconds, injection molding	42		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	2.41	MPa	ASTM D412
Tensile Strength (Break)	10.3	MPa	ASTM D412

Tensile Elongation (Break)	700	%	ASTM D412
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.	138 - 160	°C	
Cylinder Zone 2 Temp.	149 - 171	°C	
Cylinder Zone 3 Temp.	160 - 182	°C	
Cylinder Zone 4 Temp.	182 - 204	°C	
Cylinder Zone 5 Temp.	188 - 204	°C	
Die Temperature	199 - 216	°C	

Extrusion instructions

Screw Speed: 30 to 100 rpm

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