

Monprene® RG-69230 XRD1

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® RG-69230 XRD1 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 injection molding.

Monprene® The main features of RG-69230 XRD1 are:

- low hardness
- Strong adhesion
- high liquidity

Typical application areas include:

- Handle
- engineering/industrial accessories
- Electrical/electronic applications
- electrical appliances
- Tools

General Information			
Features	Low Specific Gravity		
	Low density		
	smoothness		
	Adhesiveness		
	High liquidity		
	Hardness, low		
Uses	Handle		
	overmolding		
	Electrical appliances		
	Power/other tools		
	Soft handle		
	Mobile phone		
	Sporting goods		
	Stationery		
	Knob		
	Dental application field		
	Toothbrush handle		
	Bonding		
Appearance	Opacity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.958	g/cm ³	ASTM D792

Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	34		ASTM D2240
Shaw A, 5 seconds	30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	2.76	MPa	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Additional Information	Nominal Value		
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	138 - 188	°C	
Middle Temperature	154 - 199	°C	
Front Temperature	154 - 216	°C	
Nozzle Temperature	154 - 221	°C	
Processing (Melt) Temp	166 - 221	°C	
Mold Temperature	10.0 - 32.2	°C	
Injection Pressure	1.38 - 5.52	MPa	
Back Pressure	0.172 - 0.862	MPa	
Screw Speed	50 - 100	rpm	
Cushion	3.81 - 25.4	mm	
Injection instructions			
潮湿会使材料降解.建议进行干燥处理.可以把材料放入除湿干燥机,在140°F的温度下干燥2-4小时.			
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	138 - 149	°C	
Cylinder Zone 2 Temp.	149 - 160	°C	
Cylinder Zone 3 Temp.	160 - 182	°C	
Cylinder Zone 5 Temp.	171 - 193	°C	
Die Temperature	182 - 204	°C	

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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

