

# Monprene® SP-14986 XRD1 PRELIMINARY DATA)

Thermoplastic Elastomer  
Teknor Apex Company

**Message:**  
Monprene SP-14986 XRD1 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications, including sports and recreation applications, requiring a soft, rubber-like feel. Monprene SP-14986 XRD1 is a low density, high hardness, lubricated grade that exhibits a high flow. This grade is suitable for injection molding.

General Information			
Features	Sunlight Resistant		
	Low density		
	Good UV resistance		
	Good liquidity		
	Good flexibility		
	Good tear strength		
	Good coloring		
	Good wear resistance		
	Good toughness		
	High hardness		
Uses	Water Sports Equipment		
	Sporting goods		
	Rubber substitution		
	Swimming Pool Supplies		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.890	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	88		ASTM D2240

Shore A, 5 seconds, injection molding	86		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress <sup>1</sup>			ASTM D412
Transverse flow: 100% strain	7.03	MPa	ASTM D412
Flow: 100% strain	6.27	MPa	ASTM D412
Transverse flow: 300% strain	8.52	MPa	ASTM D412
Flow: 300% strain	7.72	MPa	ASTM D412
Tensile Strength <sup>2</sup>			ASTM D412
Transverse flow: Fracture	19.0	MPa	ASTM D412
Flow: Fracture	17.2	MPa	ASTM D412
Tensile Elongation <sup>3</sup>			ASTM D412
Transverse flow: Fracture	640	%	ASTM D412
Flow: Fracture	680	%	ASTM D412
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	20	%	ASTM D2863
Legal statement			

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Injection	Nominal Value	Unit
Rear Temperature	193 - 216	°C
Middle Temperature	193 - 216	°C
Front Temperature	193 - 216	°C
Nozzle Temperature	193 - 216	°C
Processing (Melt) Temp	193 - 216	°C
Mold Temperature	16 - 32	°C
Injection Pressure	1.38 - 6.89	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.172 - 0.345	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).	
NOTE	
1.	C mold, 510mm/min
2.	C mold, 510mm/min
3.	C mold, 510mm/min

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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



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