Monprene® IN-22940D (PRELIMINARY DATA)

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene IN-22940D is a high performance thermoplastic elastomer, available in BLK or NAT, designed for industrial applications. Monprene IN-22940D is a high hardness, low density, UV stabilized grade that is suitable for both injection molding and extrusion.

General Information	
Features	Low Specific Gravity Without Fillers Low density Light stabilization Good UV resistance Workability, good Good coloring Good adhesion Low liquidity Good chemical resistance Good weather resistance Good toughness High hardness Elastic
Uses	Plug Washer Industrial application Rubber substitution Consumer goods application field Profile Knob
RoHS Compliance	RoHS compliance
Appearance	Black Natural color
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method

Density	0.900	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore D, 1 second, injection molding	42		ASTM D2240
Shore D, 5 seconds, injection molding	40		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [1]			ASTM D412
Transverse flow: 100% strain	7.60	MPa	ASTM D412
Flow: 100% strain	10.5	MPa	ASTM D412
Transverse flow: 300% strain	8.21	MPa	ASTM D412
Flow: 300% strain	11.4	MPa	ASTM D412
Tensile Strength [2]			ASTM D412
Transverse flow: Fracture	15.4	MPa	ASTM D412
Flow: Fracture [3]	16.6	MPa	ASTM D412
Flow: Fracture	12.5	MPa	ASTM D412
Tensile Elongation [4]			ASTM D412
Transverse flow: Fracture	830	%	ASTM D412
Flow: Fracture [5]	690	%	ASTM D412
Flow: Fracture	460	%	ASTM D412
Compression Set [6]			ASTM D395B
23°C, 22 hr	53	%	ASTM D395B
70°C, 22 hr	89	%	ASTM D395B
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (200°C, 206 sec^-1)	360	Pa·s	ASTM D3835

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	216 - 238	°C
Middle Temperature	216 - 238	°C
Front Temperature	216 - 238	°C
Nozzle Temperature	216 - 238	°C
Processing (Melt) Temp	216 - 238	°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).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	204 - 227	°C
Cylinder Zone 2 Temp.	204 - 227	°C
Cylinder Zone 3 Temp.	204 - 227	°C
Cylinder Zone 4 Temp.	204 - 227	°C
Cylinder Zone 5 Temp.	204 - 227	°C
Die Temperature	204 - 227	°C

Extrusion instructions
螺杆转速30 - 100 rpm

NOTE	
1.	C mold, 510mm/min
2.	C mold, 510mm/min
3.	Extruded tape
4.	C mold, 510mm/min
5.	Extruded tape
6.	Type 1

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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