

Monprene® WR-12233

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® WR-12233 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.

Monprene® The main features of the WR-12233 are:

low hardness

Wear-resistant

Typical application areas include:

Hose

business/office supplies

Consumer goods

General Information			
Features	Low Specific Gravity		
	Low density		
	smoothness		
	Good wear resistance		
	Hardness, low		
Uses	Pipe fittings		
	Stationery		
	Consumer goods application field		
Appearance	Clear/transparent		
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) (200°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	2.0	%	ASTM D955
Transverse flow	1.7	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	36		ASTM D2240
Shore A, 5 seconds, injection molding	33		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	2.07	MPa	ASTM D412
Tensile Strength (Break)	4.14	MPa	ASTM D412

Tensile Elongation (Break)	650	%	ASTM D412
Tear Strength ¹			ASTM D624
Transverse flow	15.8	kN/m	ASTM D624
Flow	14.5	kN/m	ASTM D624
Compression Set ²			ASTM D395B
23°C, 22 hr	13	%	ASTM D395B
70°C, 22 hr	38	%	ASTM D395B
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	< -60.0	°C	ASTM D746
Additional Information			

油脂膨胀,50°C - 12%耐醇性,PDL耐受等级 = 6耐酸性和耐碱性,PDL耐受等级 = 8

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

无需干燥.但如果湿度过大,则将粒料在150°F (65°C)的温度下干燥2-4小时.

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

螺杆转速30 - 100 rpm

NOTE

1. C mould
2. Type 1

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