

Monprene® OM-10270-01

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-10270-01 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 characteristics of the OM-10270-01 are: flame retardant/rated flame.

Typical application areas include:

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

General Information

Uses	Handle overmolding Electrical appliances Power/other tools Soft handle Mobile phone Sporting goods Stationery Knob Dental application field Toothbrush handle Bonding
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Appearance	Opacity
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Forms	Particle
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Processing Method	Extrusion Injection molding
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Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	2.0	g/10 min	ASTM D1238
200°C/5.0 kg	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	65		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	8.96	MPa	ASTM D412

Tensile Elongation (Break)	510	%	ASTM D412
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
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 - 160	°C
Middle Temperature	182 - 199	°C
Front Temperature	182 - 199	°C
Nozzle Temperature	193 - 210	°C
Processing (Melt) Temp	177 - 199	°C
Mold Temperature	4.44 - 48.9	°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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