

Monprene® CP-38138 XRD4 (PRELIMINARY DATA)

Thermoplastic Elastomer
Teknor Apex Company

Message:
Monprene CP-38138 XRD4 is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-38138 XRD4 is a low hardness, low density, clear grade that is suitable for cast film and extrusion.

General Information	
Features	Low density
	Workability, good
	Good formability
	Good melt strength
	Good flexibility
	Good tear strength
	Good coloring
	Good adhesion
	Low liquidity
	Good toughness
	Halogen-free
	Extended tensile rate
	Hardness, low
	Elastic
Uses	Handle
	overmolding
	Films
	Plug
	Washer
	Diaphragm
	Pipe fittings
	Seals
	Soft touch application
	Soft handle
	General
	Rubber substitution
	Consumer goods application field
	Profile
	Knob

RoHS Compliance	RoHS compliance
Appearance	Available colors Clear/transparent Natural color
Forms	Particle
Processing Method	Extrusion cast film

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.878	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	30	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	40		ASTM D2240
Shore A, 5 seconds, injection molding	38		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ¹			ASTM D412
Transverse flow: 100% strain	0.676	MPa	ASTM D412
Flow: 100% strain	2.31	MPa	ASTM D412
Transverse flow: 300% strain	1.32	MPa	ASTM D412
Flow: 300% strain	3.19	MPa	ASTM D412
Tensile Strength ²			ASTM D412
Transverse flow: Fracture	9.49	MPa	ASTM D412
Flow: Fracture	4.87	MPa	ASTM D412
Tensile Elongation ³			ASTM D412
Transverse flow: Fracture	610	%	ASTM D412
Flow: Fracture	610	%	ASTM D412
Tear Strength ⁴			ASTM D624
Transverse flow	31.9	kN/m	ASTM D624
Flow	22.8	kN/m	ASTM D624
Compression Set ⁵ (23°C, 22 hr)	17	%	ASTM D395B

Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	171 - 227	°C

Middle Temperature	171 - 227	°C
Front Temperature	171 - 227	°C
Nozzle Temperature	171 - 227	°C
Processing (Melt) Temp	171 - 227	°C
Mold Temperature	16 - 32	°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

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.	171 - 227	°C
Cylinder Zone 2 Temp.	171 - 227	°C
Cylinder Zone 3 Temp.	171 - 227	°C
Cylinder Zone 4 Temp.	171 - 227	°C
Cylinder Zone 5 Temp.	171 - 227	°C
Die Temperature	171 - 227	°C

Extrusion instructions

Screw Speed: 30 to 100 rpm

NOTE

1. C mold, 510mm/min
2. C mold, 510mm/min
3. C mold, 510mm/min
4. C mold, 510mm/min
5. Type 1

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