

Teknor Apex Monprene® MP-1644L3 Thermoplastic Elastomer

Category : Polymer , Thermoplastic , Elastomer, TPE

Material Notes:

Uses: Closures; Consumer Applications; Gaskets; Handles; Kitchenware; Medical/Healthcare Applications; Packaging; Safety Equipment; Sporting Goods; Toothbrush Handles; Tubing; Writing Instruments Forms: Pellets Processing Method: Extrusion; Injection Molding

Injection Notes: Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C); Injection Rate:

Fast Extrusion Notes: Screw Speed: 30 to 100 rpm Information Provided by Teknor Apex

Order this product through the following link:

http://www.lookpolymers.com/polymer_Teknor-Apex-Monprene-MP-1644L3-Thermoplastic-Elastomer.php

Physical Properties	Metric	English	Comments
Specific Gravity	0.880 g/cc	0.880 g/cc	ASTM D792
Linear Mold Shrinkage	0.023 cm/cm	0.023 in/in	ASTM D955
Linear Mold Shrinkage, Transverse	0.027 cm/cm	0.027 in/in	ASTM D955
Melt Flow	25.0 g/10 min @Load 2.16 kg, Temperature 190 °C	25.0 g/10 min @Load 4.76 lb, Temperature 374 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Shore A	37	37	ASTM D2240
Tensile Strength at Break	7.58 MPa	1100 psi	ASTM D412
Tensile Stress	2.07 MPa @Strain 300 %	300 psi @Strain 300 %	ASTM D412
Elongation at Break	700 %	700 %	ASTM D412

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	182 - 232 °C	360 - 450 °F	
Middle Barrel Temperature	188 - 238 °C	370 - 460 °F	
Front Barrel Temperature	193 - 243 °C	380 - 470 °F	
Nozzle Temperature	199 - 249 °C	390 - 480 °F	
Zone 1	182 - 232 °C	360 - 450 °F	
Zone 2	188 - 238 °C	370 - 460 °F	
Zone 3	193 - 243 °C	380 - 470 °F	

Processing Properties	Metric	English	Comments
Die Temperature	199 - 249 Â°C	390 - 480 Â°F	
Melt Temperature	199 - 249 Â°C	390 - 480 Â°F	Processing Temperature
Mold Temperature	35.0 - 48.9 Â°C	95.0 - 120 Â°F	
Injection Pressure	1.38 - 5.52 MPa	200 - 800 psi	
Back Pressure	0.172 - 0.689 MPa	25.0 - 100 psi	
Cushion	0.381 - 2.54 cm	0.150 - 1.00 in	
Screw Speed	50 - 100 rpm	50 - 100 rpm	

Descriptive Properties	Value	Comments
Appearance	Clear/Transparent	

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