



Monprene® CP-13130

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene CP-13130 is a high performance thermoplastic elastomer designed for a variety of consumer product applications. Monprene CP-13130 is a lubricated, low hardness, low density grade that is suitable for injection molding or extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Clean/High Purity • Good Colorability • Good Processability	• Halogen Free • Low Density • Low Flow • Low Hardness	• Low Specific Gravity • Lubricated • Slip • Without Fillers
Uses	• Consumer Applications • Gaskets	• Handles • Rubber Replacement	• Tubing
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.880		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	300	psi	ASTM D412
Tensile Strength (Break)	1200	psi	ASTM D412
Tensile Elongation (Break)	700	%	ASTM D412
Compression Set			ASTM D395
73°F, 22 hr	20	%	
158°F, 22 hr	60	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	37		
Shore A, 5 sec, Injection Molded	35		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	360 to 450	°F
Middle Temperature	370 to 460	°F
Front Temperature	380 to 470	°F

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Injection	Nominal Value	Unit
Nozzle Temperature	390 to 480	°F
Processing (Melt) Temp	390 to 480	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
Injection Rate	Fast	
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

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).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	360 to 450	°F
Cylinder Zone 2 Temp.	370 to 460	°F
Cylinder Zone 3 Temp.	380 to 470	°F
Cylinder Zone 4 Temp.	379 to 469	°F
Cylinder Zone 5 Temp.	390 to 480	°F
Die Temperature	390 to 480	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.