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TEKNOR APEX

# Monprene® CP-19129

## Teknor Apex Company - Thermoplastic Elastomer

### General Information

**Product Description**

Monprene CP-19129 is a general purpose thermoplastic elastomer, available in NAT and BLK, designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-19129 is a clear, low hardness, low density grade that exhibits excellent slip characteristics, is ablation resistant, and suitable for injection molding and extrusion.

**General**

| | | | |
|---|---|---|---|
| Material Status | • Commercial: Active | | |
| Availability | • Africa & Middle East<br>• Asia Pacific | • Europe<br>• Latin America | • North America |
| Additive | • Optical Brightener and Blueing Agent | | |
| Features | • Ablation Resistant<br>• Ablative<br>• Chemical Resistant<br>• Good Adhesion<br>• Good Flexibility | • Good Processability<br>• Good Toughness<br>• Low Density<br>• Low Hardness<br>• Low Specific Gravity | • Lubricated<br>• Slip<br>• Without Fillers |
| Uses | • Bushings<br>• Consumer Applications<br>• Diaphragms<br>• Gaskets | • General Purpose<br>• Grommets<br>• Handles<br>• Plugs | • Rubber Replacement<br>• Soft Touch Applications<br>• Writing Instruments |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Black<br>• Clear/Transparent | • Colors Available<br>• Natural Color | |
| Forms | • Pellets | | |
| Processing Method | • Extrusion | • Injection Molding | |

### ASTM & ISO Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 0.890 | | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (200°C/5.0 kg) | 1.5 | g/10 min | ASTM D1238 |
| **Elastomers** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Stress [2] | | | ASTM D412 |
| Across Flow : 100% Strain | 342 | psi | |
| Flow : 100% Strain | 308 | psi | |
| Tensile Stress [2] | | | ASTM D412 |
| Across Flow : 300% Strain | 389 | psi | |
| Flow : 300% Strain | 358 | psi | |
| Tensile Strength [2] | | | ASTM D412 |
| Across Flow : Break | 1300 | psi | |
| Flow : Break | 1030 | psi | |
| Tensile Elongation [2] | | | ASTM D412 |
| Across Flow : Break | 1300 | % | |
| Flow : Break | 1400 | % | |
| Tear Strength [2] | | | ASTM D624 |
| Across Flow | 159 | lbf/in | |
| Flow | 122 | lbf/in | |

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| Elastomers | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Compression Set [3] | | | ASTM D395B |
| 73°F, 22 hr | 8.4 | % | |
| 158°F, 22 hr | 55 | % | |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Durometer Hardness | | | ASTM D2240 |
| Shore A, 1 sec, Injection Molded | 32 | | |
| Shore A, 5 sec, Injection Molded | 29 | | |

## Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Rear Temperature | 420 to 460 | °F |
| Middle Temperature | 420 to 460 | °F |
| Front Temperature | 420 to 460 | °F |
| Nozzle Temperature | 420 to 460 | °F |
| Processing (Melt) Temp | 420 to 460 | °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. | 400 to 440 | °F |
| Cylinder Zone 2 Temp. | 400 to 440 | °F |
| Cylinder Zone 3 Temp. | 400 to 440 | °F |
| Cylinder Zone 4 Temp. | 400 to 440 | °F |
| Cylinder Zone 5 Temp. | 400 to 440 | °F |
| Die Temperature | 400 to 440 | °F |

**Extrusion Notes**

Screw Speed: 30 to 100 rpm

### Notes

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

[2] Die C, 20 in/min

[3] Type 1