



# Monprene® CP-32054G CLR (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

## General Information

### Product Description

Monprene CP-32054G CLR is a very soft clear thermoplastic elastomer gel designed for a variety of consumer product applications. Monprene CP-32054G CLR is a low density, high flow, high elasticity grade that is suitable for injection molding or extrusion.

### General

|                   |                                                                                 |                                                                     |                                             |
|-------------------|---------------------------------------------------------------------------------|---------------------------------------------------------------------|---------------------------------------------|
| Material Status   | • Commercial: Active                                                            |                                                                     |                                             |
| Availability      | • Africa & Middle East<br>• Asia Pacific                                        | • Europe<br>• Latin America                                         | • North America                             |
| Features          | • Bondability<br>• Contact Clarity<br>• Good Colorability<br>• Good Moldability | • High Elasticity<br>• High Flow<br>• Low Density<br>• Low Hardness | • Low Specific Gravity<br>• Without Fillers |
| Uses              | • Consumer Applications<br>• Handles                                            | • Rubber Replacement<br>• Seals                                     | • Soft Touch Applications                   |
| RoHS Compliance   | • RoHS Compliant                                                                |                                                                     |                                             |
| Appearance        | • Clear/Transparent                                                             | • Natural Color                                                     |                                             |
| Forms             | • Pellets                                                                       |                                                                     |                                             |
| Processing Method | • Extrusion                                                                     | • Injection Molding                                                 |                                             |

## ASTM & ISO Properties <sup>1</sup>

| Physical                                  | Nominal Value | Unit     | Test Method |
|-------------------------------------------|---------------|----------|-------------|
| Density / Specific Gravity                | 0.880         |          | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (150°C/2.16 kg) | 27            | g/10 min | ASTM D1238  |
| Elastomers                                | Nominal Value | Unit     | Test Method |
| Tensile Stress (300% Strain)              | 60.0          | psi      | ASTM D412   |
| Tensile Strength (Break)                  | 400           | psi      | ASTM D412   |
| Tensile Elongation (Break)                | 700           | %        | ASTM D412   |
| Hardness                                  | Nominal Value | Unit     | Test Method |
| Durometer Hardness                        |               |          | ASTM D2240  |
| Shore A, 1 sec, Injection Molded          | 8             |          |             |
| Shore OO, 1 sec, Injection Molded         | 58            |          |             |

## Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Rear Temperature       | 260 to 300    | °F   |
| Middle Temperature     | 260 to 300    | °F   |
| Front Temperature      | 260 to 300    | °F   |
| Nozzle Temperature     | 260 to 300    | °F   |
| Processing (Melt) Temp | 260 to 300    | °F   |
| Mold Temperature       | 60 to 90      | °F   |

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| Injection          | Nominal Value | Unit |
|--------------------|---------------|------|
| Injection Pressure | 200 to 800    | psi  |
| Injection Rate     | Slow-Moderate |      |
| 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. | 240 to 280    | °F   |
| Cylinder Zone 2 Temp. | 240 to 280    | °F   |
| Cylinder Zone 3 Temp. | 240 to 280    | °F   |
| Cylinder Zone 4 Temp. | 240 to 280    | °F   |
| Cylinder Zone 5 Temp. | 240 to 280    | °F   |
| Die Temperature       | 240 to 280    | °F   |

### Extrusion Notes

Screw Speed: 30 to 100 rpm

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.