+135-3858-6433 (GuangDong)
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TEKNOR APEX

Monprene® CP-28133

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene CP-28133 is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene CP-28133 is a 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	• Bondability • Contact Clarity • Good Colorability • Good Melt Strength • Good Mold Release	• Good Moldability • Good Processability • High Elongation • Low Density • Low Flow	• Low Hardness • Low Specific Gravity • Lubricated • Slip • Without Fillers
Uses	• Consumer Applications • Gaskets	• Handles • Tubing	
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	• Translucent
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)	4.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	134	psi	
Flow : 100% Strain	224	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	210	psi	
Flow : 300% Strain	304	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	1330	psi	
Flow : Break	381	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	840	%	
Flow : Break	500	%	
Tear Strength [2]			ASTM D624
Across Flow	129	lbf/in	
Flow	96.0	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	14	%	
158°F, 22 hr	31	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	38		
Shore A, 5 sec, Injection Molded	35		

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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	400 to 440	°F
Middle Temperature	400 to 440	°F
Front Temperature	400 to 440	°F
Nozzle Temperature	400 to 440	°F
Processing (Melt) Temp	400 to 440	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
Injection Rate	Moderate-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.	380 to 420	°F
Cylinder Zone 2 Temp.	380 to 420	°F
Cylinder Zone 3 Temp.	380 to 420	°F
Cylinder Zone 4 Temp.	380 to 420	°F
Cylinder Zone 5 Temp.	380 to 420	°F
Die Temperature	380 to 420	°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