



Monprene® CP-29353 NAT XRD1 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose • High Flow • Low Density	• Low Specific Gravity • Lubricated • Medium Hardness	• Slip • Without Fillers
Uses	• Consumer Applications	• Gaskets	• Handles
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	45	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	250	psi	
Flow : 100% Strain	455	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	420	psi	
Flow : 300% Strain	635	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	853	psi	
Flow : Break	819	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	690	%	
Flow : Break	540	%	
Tear Strength ²			ASTM D624
Across Flow	183	lbf/in	
Flow	142	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	20	%	
158°F, 22 hr	77	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec	55		
Shore A, 5 sec	53		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	260 to 300	°F
Middle Temperature	280 to 320	°F
Front Temperature	300 to 340	°F

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Injection	Nominal Value	Unit
Nozzle Temperature	340 to 380	°F
Processing (Melt) Temp	340 to 380	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
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.	280 to 300	°F
Cylinder Zone 2 Temp.	300 to 320	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 5 Temp.	340 to 380	°F
Die Temperature	360 to 400	°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