



Monprene® IN-32178 XRD1 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

General

Material Status	• Preliminary Data	
Availability	• Asia Pacific	
Uses	• Consumer Applications	• General Purpose
RoHS Compliance	• RoHS Compliant	
Appearance	• Black	• Natural Color
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.962		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	725	psi	ASTM D412
Tensile Strength (Break)	1160	psi	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Tear Strength	286	lbf/in	ASTM D624
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 1 sec)	78		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	374 to 410	°F
Middle Temperature	392 to 428	°F
Front Temperature	410 to 446	°F
Nozzle Temperature	419 to 446	°F
Processing (Melt) Temp	410 to 446	°F
Mold Temperature	95 to 150	°F

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.	374 to 410	°F
Cylinder Zone 2 Temp.	392 to 428	°F
Cylinder Zone 3 Temp.	410 to 446	°F
Cylinder Zone 5 Temp.	410 to 446	°F
Die Temperature	410 to 446	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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