+135-3858-6433 (GuangDong)
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TEKNOR APEX

Monprene® IN-15065

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene IN-15065 is a general purpose thermoplastic elastomer designed for the industrial market. Monprene IN-15065 is a medium hardnes, low density, RoHS compliant grade that exhibits low flow characteristics and is suitable for injection molding and extrusion.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Colorability • Good Melt Strength • Good Mold Release	• Good Moldability • Good Processability • Low Density • Low Flow	• Low Specific Gravity • Medium Hardness • Without Fillers
Uses	• Consumer Applications • Gaskets	• Handles • Industrial Applications	• Tubing • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent	• Colors Available	• 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)	1.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	380	psi	
Flow : 100% Strain	558	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	680	psi	
Flow : 300% Strain	873	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	1700	psi	
Flow : Break	1020	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	660	%	
Flow : Break	440	%	
Tear Strength [2]			ASTM D624
Across Flow	286	lbf/in	
Flow	220	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	18	%	
158°F, 22 hr	88	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	67		
Shore A, 5 sec, Injection Molded	65		

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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