+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

TEKNOR APEX

Monprene® MP-1500

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene MP-1500 is a thermoplastic elastomer designed for the consumer market. Monprene MP-1500 is a medium hardness grade that exhibits low compression set, good abrasion and chemical resistance, 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	• Abrasion Resistant • Chemical Resistant • Good Colorability	• Good Melt Strength • Good Tear Strength • Good Weather Resistance	• Low Compression Set
Uses	• Consumer Applications • Gaskets • Handles • Household Goods	• Kitchenware • Outdoor Applications • Packaging • Rubber Replacement	• Safety Equipment • Strain Reliefs • White Goods & Small Appliances • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.892		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 (100% Strain)	339	psi	ASTM D412
Tensile Strength (Break)	1020	psi	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Compression Set (73°F, 22 hr)	11	%	ASTM D395
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A	65		
Shore A, 5 sec	63		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	360 to 450	°F
Middle Temperature	370 to 460	°F
Front Temperature	380 to 470	°F

+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

Monprene® MP-1500

Teknor Apex Company - Thermoplastic Elastomer

Injection	Nominal Value	Unit
Nozzle Temperature	390 to 480	°F
Processing (Melt) Temp	390 to 480	°F
Mold Temperature	95 to 120	°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.	360 to 450	°F
Cylinder Zone 2 Temp.	370 to 460	°F
Cylinder Zone 3 Temp.	380 to 470	°F
Cylinder Zone 4 Temp.	380 to 470	°F
Cylinder Zone 5 Temp.	390 to 480	°F
Die Temperature	390 to 480	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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