



Monprene® MP-1452A (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
Uses	• Closures • Consumer Applications • Gaskets • Handles	• Kitchenware • Medical/Healthcare Applications • Packaging • Safety Equipment	• Sporting Goods • Toothbrush Handles • Tubing • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.882		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	0.90	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	406	psi	ASTM D412
Tensile Strength (Break)	580	psi	ASTM D412
Tensile Elongation (Break)	450	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 1 sec)	48		ASTM D2240

Processing Information

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

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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 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.