



Monprene® MP-1426D XRD3 (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 • Packaging • Sealing Devices	• Seals • Tubing • Weatherstripping
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.980		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	0.50	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	850	psi	ASTM D412
Tensile Strength (Break)	1350	psi	ASTM D412
Tensile Elongation (Break)	800	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec	67		
Shore A, 5 sec	63		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	380 to 440	°F
Middle Temperature	390 to 450	°F
Front Temperature	400 to 460	°F
Nozzle Temperature	400 to 460	°F
Processing (Melt) Temp	400 to 470	°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.