



Monprene® MP-2465A

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene MP-2465A is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene MP-2465A is a lubricated, medium hardness grade, suitable for injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Filled • High Density	• Low Flow • Lubricated	• Medium Hardness • Slip
Uses	• Consumer Applications • Gaskets • Handles	• Safety Equipment • Sporting Goods • Tubing	• Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color	• Opaque	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.50	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	433	psi	
Flow : 100% Strain	564	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	583	psi	
Flow : 300% Strain	721	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	1540	psi	
Flow : Break	1200	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	710	%	
Flow : Break	590	%	
Tear Strength ²			ASTM D624
Across Flow	226	lbf/in	
Flow	210	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	29	%	
158°F, 22 hr	63	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	78		
Shore A, 5 sec, Injection Molded	75		

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Processing Information		
Injection	Nominal Value	Unit
Rear Temperature	440 to 480	°F
Middle Temperature	440 to 480	°F
Front Temperature	440 to 480	°F
Nozzle Temperature	440 to 480	°F
Processing (Melt) Temp	440 to 480	°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.	420 to 460	°F
Cylinder Zone 2 Temp.	420 to 460	°F
Cylinder Zone 3 Temp.	420 to 460	°F
Cylinder Zone 4 Temp.	420 to 460	°F
Cylinder Zone 5 Temp.	420 to 460	°F
Die Temperature	420 to 460	°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		