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

TEKNOR APEX

Monprene® PC-19937D NAT (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description		
Monprene PC-19937D NAT available in NAT and colors, a high hardness grade that is suitable for injection molding.		
General		
Material Status	• Preliminary Data	
Availability	• Asia Pacific	
Features	• High Hardness	• Low Density
Uses	• Personal Care	
RoHS Compliance	• RoHS Compliant	
Appearance	• Natural Color	
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.902		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	7.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Break)	2180	psi	ASTM D412
Tensile Elongation [2] (Break)	320	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore D, 1 sec, Injection Molded	39		
Shore D, 5 sec, Injection Molded	36		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	3.0	hr
Rear Temperature	428 to 482	°F
Middle Temperature	428 to 482	°F
Front Temperature	428 to 482	°F
Nozzle Temperature	428 to 500	°F
Processing (Melt) Temp	428 to 500	°F
Mold Temperature	104 to 140	°F
Injection Rate	Fast	
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm

Injection	Nominal Value	Unit
Cushion	0.150 to 1.00	in
Screw L/D Ratio	20.0:1.0	

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).

Notes

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

[2] Die C, 20 in/min