+135-3858-6433 (GuangDong)
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TEKNOR APEX

Monprene® RG-65050 ORG Q910

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene RG-65050 ORG Q910 is a specialty thermoplastic elastomer used in regulated consumer applications and complies with various US FDA and European regulations and directives for food contact. Monprene RG-65050 ORG Q910 is a low hardness, low density, RoHS compliant grade that exhibits excellent bondability to PP and has high flow designed for extrusion, injection and multi-cavity injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Barrier Resin • Food Contact Acceptable • Good Adhesion • Good Colorability • Good Melt Strength	• Good Organoleptic Properties • Good Processability • Halogen Free • High Elongation • High Tensile Strength	• Low Compression Set • Low Density • Low Hardness • Oxygen Barrier
Uses	• Closures • Consumer Applications • Cookware Handles • Cups • Film • Fluid Handling	• Food Containers • Food Packaging • Food Service Applications • Gaskets • Kitchenware • Lids	• Non-specific Food Applications • Overmolding • Toothbrush Handles • Toys • Tubing
Agency Ratings	• EU Food Contact	• FDA	
RoHS Compliance	• RoHS Compliant		
Appearance	• Orange		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/5.0 kg)	9.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	193	psi	
Flow : 100% Strain	339	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	270	psi	
Flow : 300% Strain	446	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	1390	psi	
Flow : Break	655	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	> 1000	%	
Flow : Break	670	%	
Tear Strength [2]			ASTM D624
Across Flow	198	lbf/in	
Flow	166	lbf/in	

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Elastomers	Nominal Value	Unit	Test Method
Compression Set [3]			ASTM D395B
73°F, 22 hr	17	%	
158°F, 22 hr	92	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	54		
Shore A, 5 sec, Injection Molded	52		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	340 to 440	°F
Middle Temperature	340 to 440	°F
Front Temperature	340 to 440	°F
Nozzle Temperature	340 to 440	°F
Processing (Melt) Temp	340 to 440	°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.	340 to 440	°F
Cylinder Zone 2 Temp.	340 to 440	°F
Cylinder Zone 3 Temp.	340 to 440	°F
Cylinder Zone 4 Temp.	340 to 440	°F
Cylinder Zone 5 Temp.	340 to 440	°F
Die Temperature	340 to 440	°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