



Monprene® SP-18550 NAT XRD3 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene SP-18550 NAT XRD3 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Low Density	• Medium Flow	
Uses	• Consumer Applications	• Sporting Goods	
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color	• Translucent	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.932		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/10.0 kg)	5.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	682	psi	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, Injection Molded)	70		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	380 to 420	°F
Middle Temperature	380 to 420	°F
Front Temperature	380 to 420	°F
Nozzle Temperature	380 to 420	°F
Processing (Melt) Temp	380 to 420	°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

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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 400	°F
Cylinder Zone 2 Temp.	360 to 400	°F
Cylinder Zone 3 Temp.	360 to 400	°F
Cylinder Zone 4 Temp.	360 to 400	°F
Cylinder Zone 5 Temp.	360 to 400	°F
Die Temperature	360 to 400	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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