



Monprene® SP-29969

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene SP-29969 is a high performance thermoplastic elastomer that is designed for a variety of consumer applications including sporting goods, and is available in colors. Monprene SP-29969 is a translucent, medium hardness, low density, UV resistant grade that is designed for extrusion and also suitable for injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Abrasion Resistant • Chemical Resistant • Good Adhesion	• Good Colorability • Good Processability • Good Toughness	• Low Density • Medium Hardness • UV Resistant
Uses	• Consumer Applications • Gaskets	• Handles • Sporting Goods	
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color	• Translucent	• White
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) (200°C/5.0 kg)	24	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Flow (100% Strain)	600	psi	ASTM D412
Tensile Stress - Flow (200% Strain)	650	psi	ASTM D412
Tensile Stress - Flow (300% Strain)	700	psi	ASTM D412
Tensile Strength - Flow (Break)	1540	psi	ASTM D412
Tensile Elongation - Flow (Break)	780	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec	70		
Shore A, 5 sec	68		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	360 to 450	°F
Middle Temperature	370 to 460	°F
Front Temperature	380 to 470	°F
Nozzle Temperature	390 to 480	°F

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Injection	Nominal Value	Unit
Processing (Melt) Temp	390 to 480	°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

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 4 Temp.	390 to 480	°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.