



# Monprene® SP-29985

Teknor Apex Company - Thermoplastic Elastomer

## General Information

### Product Description

Monprene SP-29985 is a high performance thermoplastic elastomer designed for a variety of consumer applications including sporting goods and is available in colors. SP-29985 is a medium hardness, low density grade with UV resistance, that was designed for extrusion but is 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 Melt Strength • Good Processability • Good Tear Strength • Good Toughness	• Low Density • Medium Hardness • UV Resistant
Uses	• Consumer Applications • Fabric Coatings • Film	• Flexible Grips • Gaskets • Knobs	• Rubber Replacement • Soft Touch Applications • Sporting Goods
RoHS Compliance	• RoHS Compliant		
Appearance	• Black • Colors Available	• Natural Color • Translucent	• White
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.5	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	1100	psi	ASTM D412
Tensile Strength (Break)	2500	psi	ASTM D412
Tensile Elongation (Break)	600	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	85		
Shore A, 5 sec, Injection Molded	83		

## Processing Information

Injection	Nominal Value	Unit
Rear Temperature	340 to 440	°F
Middle Temperature	340 to 440	°F
Front Temperature	340 to 440	°F

# Monprene® SP-29985

## Teknor Apex Company - Thermoplastic Elastomer

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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).

<b>Extrusion</b>	<b>Nominal Value</b>	<b>Unit</b>
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

<sup>1</sup> Typical properties: these are not to be construed as specifications.