



# Monprene® SP-19220 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

## General Information

### Product Description

Monprene SP-19220, available in NAT and colors, is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene SP-19220 is a low density, low hardness, RoHS compliant grade suitable for injection molding.

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Clarity • Good Colorability • Good Flexibility • Good Mold Release • Good Moldability	• Good Processability • High Elasticity • High Flow • Low Density • Low Hardness • Low Specific Gravity	• Low Temperature Flexibility • Slip • Soft • Without Fillers
Uses	• Consumer Applications • Handles	• Rubber Replacement • Soft Touch Applications	• Toothbrush Handles • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.880		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	20	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress <sup>2</sup>			ASTM D412
Across Flow : 100% Strain	60.0	psi	
Flow : 100% Strain	60.0	psi	
Tensile Stress <sup>2</sup>			ASTM D412
Across Flow : 300% Strain	110	psi	
Flow : 300% Strain	120	psi	
Tensile Strength <sup>2</sup>			ASTM D412
Across Flow : Break	800	psi	
Flow : Break	750	psi	
Tensile Elongation <sup>2</sup>			ASTM D412
Across Flow : Break	600	%	
Flow : Break	650	%	
Tear Strength <sup>2</sup>			ASTM D624
Across Flow	65.0	lbf/in	
Flow	65.0	lbf/in	
Compression Set <sup>3</sup> (73°F, 22 hr)	30	%	ASTM D395B
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	20		
Shore A, 5 sec, Injection Molded	16		

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### Processing Information

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Injection	Nominal Value	Unit
Rear Temperature	300 to 340	°F
Middle Temperature	300 to 340	°F
Front Temperature	300 to 340	°F
Nozzle Temperature	300 to 340	°F
Processing (Melt) Temp	300 to 340	°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

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Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

#### Notes

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

<sup>2</sup> Die C, 20 in/min

<sup>3</sup> Type 1