

TECHNICAL DATA SHEET

Monprene® RG-18280

Teknor Apex Co.

TPE

Processing

Injection molding

Delivery Form

Pellets

Additives

Lubricants

Special Characteristics

Translucent

Features

Good adhesion

Certifications

Food contact, Food approval FDA 21 CFR

Applications

Packaging

Product Text

Product Information

Preliminary Data

The Monprene RG-18200 series is a group of unfilled high performance thermoplastic elastomers with high flow specifically designed for EU injection molded regulated applications including food contact, toys, and children's products. Monprene RG-18280 is a low density, medium hardness grade that complies with various US FDA and European regulations and directives for food contact and toy safety and is suitable for injection molding.

Adheres to PP

Property	Value	Unit	Standard
Apparent Viscosity (200 °C, 206 1/s)	103	Pas	ASTM D3835
Mechanical Properties		Value Unit	Standard
Modulus at 100% elongation	3.85	MPa	ASTM D 412
Modulus at 300% elongation	1.6	MPa	ASTM D 412
Shore A hardness	80		ASTM D 2240
Tensile strength at break	6.87	MPa	ASTM D 412
Elongation at break	550	%	ASTM D 412
Compression set at 23 °C, 24h	41	%	
Compression set at 70 °C, 24h	62	%	ISO 815

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Other Properties	Value	Unit	Standard
Density	890	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	65	°C	
Pre-drying - time	2 - 4	h	
Melt temperature	180 - 230	°C	
Mold temperature	15 - 50	°C	
Zone 1	120 - 160	°C	
Zone 2	160 - 230	°C	
Zone 3	180 - 230	°C	
Nozzle temperature	180 - 230	°C	
Screw speed	50 - 100	rpm	
Back pressure	0.5 - 1.5	MPa	