+135-3858-6433 (GuangDong)
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TEKNOR APEX

Monprene® RG-17279 BLK 9004

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene RG-17279 BLK 9004 is specifically designed for food contact applications and other regulated markets such as children's and infants products. Monprene RG-17279 BLK 9004 is a high hardness, medium density grade that is suitable for injection molding and extrusion. Please contact your Teknor Apex rep for a regulatory letter as required.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Food Contact Acceptable • Good Adhesion • Good Organoleptic Properties	• Good Processability • Good Strength • Good Toughness	• High Hardness • Medium Density • Medium Flow
Uses	• Closures • Consumer Applications • Cookware Handles • Grommets	• Handles • Kitchenware • Knobs • Rubber Replacement	• Toys • Tubing
Agency Ratings	• EU Food Contact	• FDA Food Contact	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.963		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 [2] (100% Strain)	499	psi	ASTM D412
Tensile Stress - Flow [2] (300% Strain)	709	psi	ASTM D412
Tensile Strength - Flow [2] (Break)	1260	psi	ASTM D412
Tensile Elongation - Flow [2] (Break)	660	%	ASTM D412
Tear Strength - Flow [2]	248	lbf/in	ASTM D624
Compression Set (73°F, 22 hr)	30	%	ASTM D395
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec	79		
Shore A, 5 sec	77		

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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
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.	380 to 470	°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.

[2] Die C, 20 in/min