Monprene® SP-29985

Teknor Apex Company - Thermoplastic Elastomer

Friday, April 3, 2026

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	

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)	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		

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Processing Information

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

Revision Date: 5/24/2019

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Injection	Nominal Value	Unit
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).

Extrusion	Nominal Value	Unit
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

[1] Typical properties: these are not to be construed as specifications.

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