

Monprene® OM-10150

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene OM-10150 is a thermoplastic elastomer designed for overmolding applications like grips and anti-skid parts for consumer products. Monprene OM-10150 is an opaque, UV resistant grade that exhibits excellent adhesion to nylon.

General Information			
Features	Low Specific Gravity		
	Sunlight Resistant		
	Without Fillers		
	Low density		
	smoothness		
	Light stabilization		
	High liquidity		
	Lubrication		
	Water Soluble		
	Medium hardness		
Uses	UV absorption		
	Handle		
	overmolding		
	Electrical appliances		
	Power/other tools		
	Soft handle		
	Mobile phone		
	Sporting goods		
	Stationery		
	Knob		
Appearance	Toothbrush handle		
	Bonding		
	Opacity		
	Particle		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.908	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	35	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240

Shaw A	53		ASTM D2240
Shaw A, 5 seconds	50		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	1.34	MPa	ASTM D412
Flow: 100% strain ²	1.63	MPa	ASTM D412
Transverse flow: 300% strain ³	2.05	MPa	ASTM D412
Flow: 300% strain ⁴	2.76	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	2.43	MPa	ASTM D412
Flow: Fracture	2.83	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	350	%	ASTM D412
Flow: Fracture	340	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	16.3	kN/m	ASTM D624
Flow	14.5	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	20	%	ASTM D395B
70°C, 22 hr	16	%	ASTM D395B

Additional Information	Nominal Value	
Adhesion to Nylon		
Legal statement		

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Injection	Nominal Value	Unit
Drying Temperature	65.6	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	204 - 232	°C
Middle Temperature	210 - 232	°C
Front Temperature	216 - 238	°C
Nozzle Temperature	221 - 243	°C
Processing (Melt) Temp	221 - 243	°C
Mold Temperature	23.9 - 60.0	°C
Injection Pressure	1.38 - 6.89	MPa
Injection Rate	Fast	
Back Pressure	0.172 - 0.862	MPa
Screw Speed	50 - 120	rpm

Cushion	3.81 - 25.4	mm
Injection instructions		
Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).		
NOTE		
1.	Mouth die C, 510mm/min	
2.	Mouth die C, 510mm/min	
3.	C mold, 510mm/min	
4.	C mold, 510mm/min	
5.	C mold, 510mm/min	
6.	Mouth die C, 510mm/min	
7.	C mold, 510mm/min	
8.	Type 1	

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