

Monprene® OM-12250-01

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene® OM-12250-01 is a thermoplastic elastomer (TPE) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is extrusion or injection molding. Monprene® The main characteristics of the OM-12250-01 are: strong adhesion.

Typical application areas include:

Handle
engineering/industrial accessories
Electrical/electronic applications
electrical appliances
Tools

General Information			
Features	Light stabilization		
	Adhesiveness		
	Low liquidity		
	Medium density		
	Medium hardness		
	UV absorption		
Uses	Handle		
	overmolding		
	Electrical appliances		
	Power/other tools		
	Soft handle		
	Mobile phone		
	Sporting goods		
	Stationery		
	Knob		
	Toothbrush handle		
	Bonding		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	1.5	g/10 min	ASTM D1238

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	53		ASTM D2240
Shore A, 5 seconds, injection molding	50		ASTM D2240

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (300% Strain)	3.10	MPa	ASTM D412
Tensile Strength (Break)	7.58	MPa	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412

Additional Information	Nominal Value
Adhesion to ABS	
Adhesion to PC	
Adhesion to PC/ABS	

Injection	Nominal Value	Unit
Drying Temperature	60.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	138 - 188	°C
Middle Temperature	154 - 199	°C
Front Temperature	154 - 216	°C
Nozzle Temperature	154 - 221	°C
Processing (Melt) Temp	166 - 221	°C
Mold Temperature	10.0 - 32.2	°C
Injection Pressure	1.38 - 5.52	MPa
Back Pressure	0.172 - 0.862	MPa
Screw Speed	50 - 100	rpm
Cushion	3.81 - 25.4	mm

Injection instructions
Moisture can degrade the material. Drying is suggested. This can be accomplished by placing the material in a desiccant dryer for 2 to 4 hours at 140°F.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	138 - 149	°C
Cylinder Zone 2 Temp.	149 - 160	°C
Cylinder Zone 3 Temp.	160 - 182	°C
Cylinder Zone 5 Temp.	160 - 182	°C
Die Temperature	160 - 182	°C

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