

Monprene® OM-12260

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene OM-12260 is designed for overmolding applications like grips and anti-skid parts for consumer products. Monprene OM-12260 is an opaque grade that exhibits excellent adhesion to PC, ABS, and PC/ABS.

General Information			
Features	Sunlight Resistant		
	Without Fillers		
	smoothness		
	Adhesiveness		
	Medium liquidity		
	Lubrication		
	Medium density		
	Medium hardness		
	UV absorption		
Uses	Handle		
	overmolding		
	Electrical appliances		
	Power/other tools		
	Soft handle		
	Mobile phone		
	Sporting goods		
	Stationery		
	Knob		
	Dental application field		
	Toothbrush handle		
	Bonding		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method

Durometer Hardness			ASTM D2240
Shaw A	63		ASTM D2240
Shaw A, 5 seconds	60		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	2.03	MPa	ASTM D412
Flow: 100% strain ²	2.15	MPa	ASTM D412
Transverse flow: 300% strain ³	3.82	MPa	ASTM D412
Flow: 300% strain ⁴	4.00	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	6.03	MPa	ASTM D412
Flow: Fracture	6.05	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	480	%	ASTM D412
Flow: Fracture	500	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	27.8	kN/m	ASTM D624
Flow	28.4	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	38	%	ASTM D395B
70°C, 22 hr	89	%	ASTM D395B
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	
Injection Rate	Moderate-Fast		
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

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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