Monprene® MP-2806B NAT XRD5 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

Product Description

Monprene MP-2806B Nat is a specialty TPE designed with low hardness, transparent and good adhesion to PC, ABS and PC/ABS.

General			
Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • North America	
Features	• High Clarity	• UV Stabilized	
Uses	• Closures • Consumer Applications • Gaskets • Handles	• Kitchenware • Medical/Healthcare Applications • Packaging • Safety Equipment	• Sporting Goods • Toothbrush Handles • Tubing • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.902		ASTM D792
Melt Mass-Flow Rate (MFR) (125°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Break, 73°F)	435	psi	ASTM D412
Tensile Elongation [2] (Break, 73°F)	400	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec	25		
Shore A, 5 sec	23		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Desiccant Dryer	104	°F
Drying Time - Desiccant Dryer	2.0	hr
Suggested Max Moisture	< 0.040	%
Rear Temperature	340 to 360	°F
Middle Temperature	350 to 370	°F
Front Temperature	360 to 380	°F
Nozzle Temperature	365 to 380	°F
Processing (Melt) Temp	365 to 385	°F
Mold Temperature	80 to 95	°F
Injection Pressure	100 to 500	psi
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Revision Date: 8/18/2023

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Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 104°F (40°C).

Notes

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

[2] 20 in/min

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