Monprene® OM-12265-02

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

General			
Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Appliances • Bonding • Cell Phones • Dental Applications	• Flexible Grips • Handles • Knobs • Overmolding	• Power/Other Tools • Sporting Goods • Toothbrush Handles • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.00		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	10	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (300% Strain)	600	psi	ASTM D412
Tensile Strength (Yield)	1200	psi	ASTM D412
Tensile Elongation (Break)	560	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A)	60		ASTM D2240
Thermal	**Nominal Value**	**Unit**	**Test Method**
RTI Elec	122	°F	UL 746B
RTI Imp	122	°F	UL 746B
RTI Str	122	°F	UL 746B
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.04 to 0.05 in, All Colors)	HB		UL 94
Additional Information	**Nominal Value**	**Unit**	
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	140	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	280 to 320	°F
Middle Temperature	360 to 390	°F
Front Temperature	360 to 419	°F
Nozzle Temperature	380 to 428	°F
Processing (Melt) Temp	350 to 428	°F
Mold Temperature	40 to 120	°F
Injection Pressure	200 to 800	psi

Revision Date: 1/9/2022

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Injection	Nominal Value	Unit
Back Pressure	25.0 to 125	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Injection Notes

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.	280 to 300	°F
Cylinder Zone 2 Temp.	300 to 320	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 5 Temp.	340 to 380	°F
Die Temperature	360 to 400	°F

Notes

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

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