Monprene® PC-12153 NAT XRD2 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Thursday, April 2, 2026

General Information

Product Description

Monprene PC-12153 NAT XRD2, available in NAT, is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene PC-12153 NAT XRD2 is a low density, low hardness, suitable for injection molding and extrusion.

General			
Material Status	• Preliminary Data		
Availability	• Asia Pacific		
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	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.892		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	12	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (100% Strain)	363	psi	ASTM D412
Tensile Stress (300% Strain)	725	psi	ASTM D412
Tensile Strength (Break)	1160	psi	ASTM D412
Tensile Elongation (Break)	480	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A	55		
Shore A, 5 sec	53		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	360 to 450	°F
Middle Temperature	370 to 460	°F
Front Temperature	380 to 470	°F
Nozzle Temperature	390 to 480	°F
Processing (Melt) Temp	390 to 480	°F
Mold Temperature	95 to 120	°F
Injection Pressure	200 to 800	psi
Injection Rate	Fast	
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

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Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	360 to 450	°F
Cylinder Zone 2 Temp.	370 to 460	°F
Cylinder Zone 3 Temp.	380 to 470	°F
Cylinder Zone 5 Temp.	390 to 480	°F
Die Temperature	390 to 480	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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

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