Monprene® PR-13250

Teknor Apex Company - Thermoplastic Elastomer

Thursday, April 2, 2026

General Information

Product Description

Monprene PR-13250 is a general purpose thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene PR-13250 is a medium hardness grade that is suitable for injection molding and extrusion.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Good Adhesion • Good Colorability • Good Dimensional Stability • Good Tear Strength	• Good Toughness • Halogen Free • Low Density • Low Specific Gravity • Lubricated	• Medium Flow • Medium Hardness • Slip • Without Fillers
Uses	• Consumer Applications • Gaskets	• Handles • Safety Equipment	• Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	• Translucent
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.890		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	20	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	210	psi	
Flow : 100% Strain	300	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	320	psi	
Flow : 300% Strain	410	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	1020	psi	
Flow : Break	590	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	730	%	
Flow : Break	530	%	
Tear Strength [2]			ASTM D624
Across Flow	175	lbf/in	
Flow	140	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	19	%	
158°F, 22 hr	44	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	55		
Shore A, 5 sec, Injection Molded	54		

Revision Date: 6/10/2024

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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	338 to 374	°F
Middle Temperature	356 to 428	°F
Front Temperature	374 to 446	°F
Nozzle Temperature	374 to 446	°F
Processing (Melt) Temp	374 to 446	°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).

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 4 Temp.	390 to 480	°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.

[2] Die C, 20 in/min

[3] Type 1

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