Monprene® OM-12260

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

Product Description

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			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Colorability • Good Mold Release • Good Moldability	• Good Processability • Light Stabilized • Lubricated • Medium Density	• Medium Flow • Medium Hardness • Slip • Without Fillers
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	• Colors Available	• Natural Color	• Opaque
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	294	psi	
Flow : 100% Strain	312	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	554	psi	
Flow : 300% Strain	580	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	875	psi	
Flow : Break	877	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	480	%	
Flow : Break	500	%	
Tear Strength [2]			ASTM D624
Across Flow	159	lbf/in	
Flow	162	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	38	%	
158°F, 22 hr	89	%	

Revision Date: 6/19/2019

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Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	63		
Shore A, 5 sec	60		

Additional Information	Nominal Value	Unit
Adhesion to ABS		
Adhesion to PC		
Adhesion to PC/ABS		

Legal Statement

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	140	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	320 to 380	°F
Middle Temperature	320 to 380	°F
Front Temperature	320 to 380	°F
Nozzle Temperature	320 to 380	°F
Processing (Melt) Temp	320 to 380	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
Injection Rate	Moderate-Fast	
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 (60°C).

For any overmolding process it is recommended that the process temperatures for the TPE material be set at least 50°F (10°C)higher than the melt temperature of the substrate material.

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	320 to 360	°F
Cylinder Zone 2 Temp.	320 to 360	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 4 Temp.	320 to 360	°F
Cylinder Zone 5 Temp.	320 to 360	°F
Die Temperature	320 to 360	°F

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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