Monprene® OM-16478 NAT XRD4 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Thursday, April 2, 2026

General Information

General			
Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Adhesion	• Good Colorability • Light Stabilized	• Slip
Uses	• Appliances • Bonding • Cell Phones • Flexible Grips	• Handles • Knobs • Overmolding • Power/Other Tools	• Toothbrush Handles • Wear Strip • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color	• Opaque	
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.05		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	45	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	2180	psi	ASTM D412
Tensile Elongation (Break)	500	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 1 sec)	74		ASTM D2240
Additional Information	**Nominal Value**	**Unit**	
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	280 to 370	°F
Middle Temperature	310 to 390	°F
Front Temperature	310 to 420	°F
Nozzle Temperature	310 to 430	°F
Processing (Melt) Temp	330 to 430	°F

Revision Date: 7/1/2025

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Injection	Nominal Value	Unit
Mold Temperature	50 to 90	°F
Injection Pressure	200 to 1000	psi
Injection Rate	Fast	
Back Pressure	25.0 to 125	psi
Screw Speed	50 to 120	rpm
Cushion	0.150 to 1.00	in

Notes

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

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