Monprene® IN-12250 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

Product Description

Monprene IN-12250 is a general purpose thermoplastic elastomer, available in Nat, BLK, and colors, designed for the industrial market, including seals and gaskets. Monprene IN-12250 is a medium hardness, high density grade with good compression set that is suitable for extrusion or injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Filled • General Purpose • Good Adhesion • Good Colorability • Good Flexibility	• Good Processability • Good Toughness • Good Weather Resistance • Halogen Free • High Density • High Specific Gravity	• Low Compression Set • Lubricated • Medium Hardness • Resilient
Uses	• Building Materials • Flexible Grips • Gaskets • Handles • Industrial Applications	• O-rings • Plugs • Profiles • Rubber Replacement • Seals	• Soft Touch Applications • Weatherstripping • White Goods & Small Appliances • Windows & Doors
RoHS Compliance	• RoHS Compliant		
Appearance	• Black • Colors Available	• Grey • Natural Color	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		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 Strength (Break)	1000	psi	ASTM D412
Tensile Elongation (Break)	770	%	ASTM D412
Compression Set (73°F, 22 hr)	20	%	ASTM D395
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 14°F	65		
Shore A, 1 sec, Injection Molded	52		
Shore A, 5 sec, Injection Molded	50		

Additional Information

CHANGE IN VOLUME (WATER) ASTM D-471 = 1.11%
OZONE RESISTANCE ASTM D-1149)= NO CRACKS

STRESS RELAXATION - INITIAL STRESS(23C) 1200 KPA
100 M HR, % OF STRESS 0.42%

Revision Date: 1/28/2019

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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	60 to 90	°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.	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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