TEKNOR APEX

# Monprene® OM-19140 NAT (PRELIMINARY DATA)

## Teknor Apex Company - Thermoplastic Elastomer

Thursday, April 2, 2026

### General Information

**Product Description**

Monprene OM-19140 is part of a series of adhesion-modified thermoplastic elastomers (available from 40 to 70 Shore A) designed for over-molding (insert and multi-shot) and co-extrusion onto polyamide (Nylon), including: PA 6, PA66, PA12, etc. These materials exhibit dry haptics and low compression set are well suited for overmolded seals or grips. Monprene OM-19140 is REACH-SVHC and RoHS compliant and offers several benefits including superior adhesion onto polystyrene and easy molding with a wide processing window.

| General | | | |
|---|---|---|---|
| Material Status | • Preliminary Data | | |
| Availability | • Africa & Middle East<br>• Asia Pacific | • Europe<br>• Latin America | • North America |
| Features | • Bondability<br>• Chemical Resistant<br>• Conformable<br>• Ductile<br>• Filled<br>• Good Colorability | • Good Compression Set<br>• Good Flexibility<br>• Good Flow<br>• Good Impact Resistance<br>• Good Moldability<br>• Halogen Free | • High Elasticity<br>• Low Compression Set<br>• Lubricated<br>• Medium Density<br>• Medium Hardness<br>• Soft |
| Uses | • Bonding<br>• Consumer Applications | • Industrial Applications<br>• Overmolding | • Soft Touch Applications |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Colors Available | • Natural Color | • Opaque |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | • Multi Injection Molding | |

### Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.08 | | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (200°C/5.0 kg) | 1.5 | g/10 min | ASTM D1238 |
| **Elastomers** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Stress [2] (50% Strain) | 105 | psi | ASTM D412 |
| Tensile Stress [3] (100% Strain) | 160 | psi | ASTM D412 |
| Tensile Strength [3] (Break) | 440 | psi | ASTM D412 |
| Tensile Elongation [3] (Break) | 390 | % | ASTM D412 |
| Tear Strength [3] | 90.0 | lbf/in | ASTM D624 |
| Compression Set | | | ASTM D395B |
| 70°F, 22 hr | 10 | % | |
| 158°F, 22 hr | 37 | % | |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Durometer Hardness | | | ASTM D2240 |
| Shore A, 1 sec, Injection Molded | 40 | | |
| Shore A, 5 sec, Injection Molded | 38 | | |
| **Additional Information** | **Nominal Value** | **Unit** | |
| Adhesion to Nylon | | | |
| Adhesion to PA6 | | | |
| Adhesion to PA66 | | | |

Revision Date: 11/23/2020

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## Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Rear Temperature | 450 to 470 | °F |
| Middle Temperature | 470 to 490 | °F |
| Front Temperature | 490 to 510 | °F |
| Nozzle Temperature | 490 to 510 | °F |
| Processing (Melt) Temp | 470 to 520 | °F |
| Mold Temperature | 90 to 130 | °F |
| Injection Pressure | 5000 to 6000 | psi |
| Injection Rate | Fast | |
| Holding Pressure | 2800 to 3000 | psi |

**Injection Notes**

Drying is recommended to achieve a moisture level <= 0.08%. Dry the pellets for 2 to 4 hours at 185°F (85°C).

For overmolding to Nylon 6,6, use higher temperature settings than the recommended processing condition.

Nylon substrate must not be exposed to open air for long, to avoid moisture adsorption.

## Notes

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

[2] 20 in/min

[3] Die C, 20 in/min

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