Monprene® IN-32930 XRD1 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

Product Description

Monprene IN-32930 XRD1 is a general purpose thermoplastic elastomer designed for a variety of industrial applications, including seals and gaskets. Monprene IN-32930 XRD1 is a low density, low hardness, RoHS compliant grade suitable for injection molding and extrusion.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Europe	• Latin America • North America	
Features	• Good Adhesion • Good Colorability • Good Processability	• Low Density • Low Flow • Low Hardness	• Low Specific Gravity • UV Stabilized • Without Fillers
Uses	• Consumer Applications • Gaskets • Handles	• Industrial Applications • Knobs • Rubber Replacement	• Soft Touch Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color	• Translucent	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.890		ISO 1183
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 - Across Flow (100% Strain)	69.6	psi	ISO 37
Tensile Stress - Across Flow (Break)	609	psi	ISO 37
Tensile Elongation - Across Flow (Break)	860	%	ISO 37
Tear Strength [2]			ISO 34-1
Across Flow	35.4	lbf/in	
Flow	69.1	lbf/in	
Compression Set			ISO 815
73°F, 22 hr	13	%	
158°F, 22 hr [3]	20	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Shore Hardness			ISO 868
Shore A, 1 sec, Injection Molded	31		
Shore A, 5 sec, Injection Molded	29		
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (392°F, 206 sec^-1)	204	Pa·s	ASTM D3835

Legal Statement

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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	320 to 350	°F
Middle Temperature	360 to 400	°F
Front Temperature	360 to 420	°F
Nozzle Temperature	360 to 440	°F
Processing (Melt) Temp	360 to 440	°F
Mold Temperature	80 to 120	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 0.500	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.	340 to 380	°F
Cylinder Zone 2 Temp.	360 to 400	°F
Cylinder Zone 3 Temp.	380 to 420	°F
Cylinder Zone 4 Temp.	380 to 420	°F
Cylinder Zone 5 Temp.	380 to 440	°F
Die Temperature	380 to 440	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

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

[2] Method Ba, Angle (Unnicked)

[3] Type A

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