Monprene® OM-10185

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

Product Description

Monprene OM-10185 is a specialty thermoplastic elastomer, available in NAT and colors, designed for overmolding and co-extrusion applications like grips and anti-skid parts for consumer and industrial products. Monprene OM-10185 is a high hardness, low density, 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	• Abrasion Resistant • Bondability • Good Color Stability • Good Colorability • Good Flow	• Good Mold Release • Good Moldability • Good Processability • Good Processing Stability • High Hardness	• Light Stabilized • Low Density • Low Specific Gravity • Medium Flow • Slip
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	0.940		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	766	psi	
Flow : 100% Strain	1210	psi	
Tensile Stress - Across Flow [2] (300% Strain)	985	psi	ASTM D412
Tensile Strength [2]			ASTM D412
Across Flow : Break	1480	psi	
Flow : Break	1480	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	560	%	
Flow : Break	230	%	
Tear Strength [2]			ASTM D624
Across Flow	362	lbf/in	
Flow	312	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	22	%	
158°F, 22 hr	94	%	

Revision Date: 5/2/2019

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Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	87		
Shore A, 5 sec, Injection Molded	85		

Additional Information	Nominal Value	Unit
Adhesion to Nylon		

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	400 to 460	°F
Middle Temperature	400 to 460	°F
Front Temperature	400 to 460	°F
Nozzle Temperature	400 to 460	°F
Processing (Melt) Temp	400 to 460	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
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.	380 to 460	°F
Cylinder Zone 2 Temp.	380 to 460	°F
Cylinder Zone 3 Temp.	380 to 460	°F
Cylinder Zone 4 Temp.	380 to 460	°F
Cylinder Zone 5 Temp.	380 to 460	°F
Die Temperature	380 to 460	°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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