Monprene® PC-16255 CLR XRD1 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Thursday, April 2, 2026

General Information

Product Description

Monprene PC-16255 CLR XRD1, available in NAT and colors, is a high performance thermoplastic elastomer designed for a variety of consumer product applications requiring a soft, rubber-like feel. Monprene PC-16255 CLR XRD1 is a low density, low hardness, RoHS compliant grade with excellent adhesion to PC and ABS co-polymers. This grade is suitable for injection molding.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Good Adhesion • Good Colorability • Good Dimensional Stability • Good Flow	• Good Moldability • Good Processability • Good Processing Stability • Good Stretchability • Good Toughness	• Halogen Free • Low Density • Low Hardness • Low Specific Gravity • Without Fillers
Uses	• Consumer Applications • General Purpose • Handles	• Knobs • Overmolding • Rubber Replacement	• Soft Touch Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.912		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	20	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Break)	725	psi	ASTM D412
Tensile Elongation - Flow [2] (Break)	500	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	57		
Shore A, 5 sec, Injection Molded	55		

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Processing Information

Injection	Nominal Value	Unit
Rear Temperature	340 to 380	°F
Middle Temperature	350 to 390	°F
Front Temperature	370 to 446	°F
Nozzle Temperature	370 to 446	°F

Revision Date: 6/20/2024

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Injection	Nominal Value	Unit
Processing (Melt) Temp	370 to 446	°F
Mold Temperature	59 to 95	°F
Injection Rate	Fast	
Back Pressure	50.0 to 100	psi
Screw Speed	20 to 70	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).

Notes

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

[2] Die C, 20 in/min

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