Monprene® OM-12250-01

Teknor Apex Company - Thermoplastic Elastomer

Wednesday, April 1, 2026

General Information

Product Description

Monprene OM-12250-01 is designed for overmolding applications for the consumer industry. Monprene OM-12250-01 is a medium density, medium hardness, opaque grade suitable for both injection molding and extrusion.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Colorability • Good Compression Set • Good Mold Release	• Good Moldability • Good Processability • Light Stabilized • Low Flow	• Medium Density • Medium Hardness • Without Fillers
Uses	• Appliances • Bonding • Cell Phones • Flexible Grips	• Handles • Knobs • Overmolding • Power/Other Tools	• Sporting Goods • 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	0.970		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress [2]			ASTM D412
Across Flow : 100% Strain	242	psi	
Flow : 100% Strain	296	psi	
Tensile Stress [2]			ASTM D412
Across Flow : 300% Strain	418	psi	
Flow : 300% Strain	479	psi	
Tensile Strength [2]			ASTM D412
Across Flow : Break	1120	psi	
Flow : Break	1100	psi	
Tensile Elongation [2]			ASTM D412
Across Flow : Break	670	%	
Flow : Break	670	%	
Tear Strength [2]			ASTM D624
Across Flow	172	lbf/in	
Flow	162	lbf/in	
Compression Set [3]			ASTM D395B
73°F, 22 hr	18	%	
158°F, 22 hr	65	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 1 sec, Injection Molded)	52		ASTM D2240

Revision Date: 4/13/2021

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Additional Information	Nominal Value	Unit
Adhesion to ABS		
Adhesion to PC		
Adhesion to PC/ABS		

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	320 to 380	°F
Middle Temperature	320 to 380	°F
Front Temperature	320 to 380	°F
Nozzle Temperature	320 to 380	°F
Processing (Melt) Temp	320 to 380	°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.

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.	320 to 360	°F
Cylinder Zone 2 Temp.	320 to 360	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 4 Temp.	320 to 360	°F
Cylinder Zone 5 Temp.	320 to 360	°F
Die Temperature	320 to 360	°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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Teknor Apex Company
Corporate Headquarters

In U.S. for Vinyls, TPEs, Colorants,

Engineered Thermoplastics (Chem Polymer)
505 Central Avenue
Pawtucket, Rhode Island 02861 U.S.

Phone: 401-725-8000
Fax: 401-725-8095
Toll Free (U.S. only) 800-556-3864

www.teknorapex.com
info@teknorapex.com

Teknor Apex B.V.

Brightlands Chemelot Campus Umonderbaan 22
6167 RD Geleen, Netherlands

Phone: +31 46 7020 950
Fax: +31 46 7020 990

www.teknorapex.com
tpe@teknorapex.com

Teknor Apex (Suzhou) Advanced Polymer Compounds Co. Pte. Ltd.

No. 78 Ping Sheng Road

Suzhou Industrial Park
Jiangsu, China 215126

Phone: (86) 512-6287-1550
Fax: (86) 512-6288-8371

www.teknorapex.com
infotaap@teknoapex.com

Teknor Apex Asia Pacific PTE. LTD.

41 Shipyard Road

Singapore 628134

Phone: (65) 6265-2544
Fax: (65) 6265-1821

www.teknorapex.com
infotaap@teknorapex.com

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