Monprene® OM-19155V XRD1 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

Thursday, April 2, 2026

General Information

Product Description

Monprene OM-19155V XRD1 is part of a series of adhesion-modified thermoplastic vulcanizates (EPDM+PP) or TPVs designed for over-molding (insert and multi-shot) and co-extrusion onto polyamide (Nylon), including: PA 6, PA66, PA12, etc. These materials exhibit low compression set and improved chemical resistance versus standard overmolding materials, and are well suited for overmolded seals or grips used in harsh environments. Monprene OM-19155V XRD1 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 • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Chemical Resistant • Conformable • Ductile • Filled • Good Colorability	• Good Flexibility • Good Flow • Good Impact Resistance • Good Moldability • Halogen Free • High Elasticity	• Lubricated • Medium Density • Medium Hardness • Soft
Uses	• Bonding • Consumer Applications	• Industrial Applications • 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	0.945		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 (50% Strain)	136	psi	ASTM D412
Tensile Stress [2] (100% Strain)	199	psi	ASTM D412
Tensile Strength [2] (Break)	414	psi	ASTM D412
Tensile Elongation [2] (Break)	330	%	ASTM D412
Tear Strength [2]	84.0	lbf/in	ASTM D624
Compression Set			
73°F, 22 hr [3]	16	%	ASTM D395B
158°F, 22 hr [3]	37	%	ASTM D395B
257°F, 22 hr	74	%	ASTM D395
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	53		
Shore A, 5 sec, Injection Molded	51		
Additional Information	**Nominal Value**	**Unit**	
Adhesion to Nylon			
Adhesion to PA6			
Adhesion to PA66			

Revision Date: 5/12/2022

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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.

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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