

# Monprene® OM-12250-01

Teknor Apex Company - Thermoplastic Elastomer

Friday, June 30, 2017

## General Information

### Product Description

Sarlink 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 • Light Stabilized • Low Flow • Medium Density • Medium Hardness • UV Absorbing • Without Fillers
Uses	• Appliances • Bonding • Cell Phones • Flexible Grips • Handles • Knobs • Overmolding • Power/Other Tools • Sporting Goods • Writing Instruments
RoHS Compliance	• RoHS Compliant
Appearance	• Opaque
Forms	• Pellets
Processing Method	• Extrusion • Injection Molding

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
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 <sup>2</sup>			ASTM D412
Across Flow : 100% Strain	242	psi	
Flow : 100% Strain	296	psi	
Tensile Stress <sup>2</sup>			ASTM D412
Across Flow : 300% Strain	418	psi	
Flow : 300% Strain	479	psi	
Tensile Strength <sup>2</sup>			ASTM D412
Across Flow : Break	1120	psi	
Flow : Break	1100	psi	
Tensile Elongation <sup>2</sup>			ASTM D412
Across Flow : Break	670	%	
Flow : Break	670	%	
Tear Strength <sup>2</sup>			ASTM D624
Across Flow	172	lbf/in	
Flow	162	lbf/in	
Compression Set <sup>3</sup>			ASTM D395B
73°F, 22 hr	18	%	
158°F, 22 hr	65	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	52		
Shore A, 1 sec, Injection Molded <sup>4</sup>	62		
Shore A, 5 sec, Injection Molded <sup>4</sup>	60		

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Revision Date: 7/13/2016

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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.

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**
- <sup>1</sup> Typical properties: these are not to be construed as specifications.
  - <sup>2</sup> Die C, 20 in/min
  - <sup>3</sup> Type 1
  - <sup>4</sup> Aged for 48 hr



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## Teknor Apex Company - Thermoplastic Elastomer

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