



Monprene® OM-10250-01 AP NAT (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Monprene OM-10250-01 AP is a specialty thermoplastic elastomer designed for overmolding and co-extrusion applications like grips and anti-skid parts for consumer and industrial products. Monprene OM-10250-01 AP is a medium hardness, low density, RoHS compliant grade that exhibits excellent adhesion to PC, ABS, and PC/ABS. This grade can be processed by injection molding and extrusion.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability • Good Flow • Good Mold Release	• Good Moldability • Light Stabilized • Low Density	• Medium Hardness • Slip • Sunlight Resistant
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	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.02		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	537	psi	ASTM D412
Tensile Elongation (Break)	400	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	50		
Shore A, 5 sec	48		
Additional Information	Nominal Value	Unit	
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	140	°F

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Injection	Nominal Value	Unit
Drying Time	2.0 to 4.0	hr
Rear Temperature	280 to 370	°F
Middle Temperature	310 to 390	°F
Front Temperature	310 to 420	°F
Nozzle Temperature	310 to 430	°F
Processing (Melt) Temp	330 to 430	°F
Mold Temperature	50 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.	280 to 300	°F
Cylinder Zone 2 Temp.	300 to 320	°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.