



Monprene® OM-16350 NAT XRD2 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

OM-16350 NAT XRD2 is a Thermoplastic Elastomer (TPE) material for injection overmolding applications. It has excellent bonding performance onto PS and HIPS substrates.

General

Material Status	• Preliminary Data		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Bondability	• Good Adhesion	• Good Colorability
Uses	• Appliances • Bonding • Cell Phones • Flexible Grips	• Handles • Knobs • Overmolding • Power/Other Tools	• Toothbrush Handles • Wear Strip • Writing Instruments
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color	• Opaque	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.00		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	30	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	580	psi	ASTM D412
Tensile Elongation (Break)	400	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 1 sec)	50		ASTM D2240
Additional Information	Nominal Value	Unit	
Adhesion to HIPS			
Adhesion to PS			

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
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

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Injection	Nominal Value	Unit
Processing (Melt) Temp	330 to 430	°F
Mold Temperature	50 to 90	°F
Injection Pressure	200 to 1000	psi
Injection Rate	Fast	
Back Pressure	25.0 to 125	psi
Screw Speed	50 to 120	rpm
Cushion	0.150 to 1.00	in

Notes

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