

Monprene® OM-12226

Thermoplastic Elastomer

Teknor Apex Company

Message:

Monprene OM-12226 is designed for overmolding applications like grips and anti-skid parts for consumer products. Monprene OM-12226 is an opaque grade that exhibits excellent adhesion to PC, ABS, and PC/ABS.

General Information			
Features	Low Specific Gravity		
	Without Fillers		
	Low density		
	smoothness		
	Adhesiveness		
	Medium liquidity		
	Lubrication		
	Hardness, low		
Uses	Handle		
	overmolding		
	Kitchen utensils		
	Sporting goods		
	Stationery		
	Consumer goods application field		
	Toothbrush handle		
Appearance	Natural color		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	12	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 second, injection molding	29		ASTM D2240
Shore A, 5 seconds, injection molding	26		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
Transverse flow: 100% strain ¹	0.538	MPa	ASTM D412

Flow: 100% strain ²	0.676	MPa	ASTM D412
Transverse flow: 300% strain ³	1.23	MPa	ASTM D412
Flow: 300% strain ⁴	1.59	MPa	ASTM D412
Tensile Strength ⁵			ASTM D412
Transverse flow: Fracture	6.83	MPa	ASTM D412
Flow: Fracture	6.38	MPa	ASTM D412
Tensile Elongation ⁶			ASTM D412
Transverse flow: Fracture	710	%	ASTM D412
Flow: Fracture	700	%	ASTM D412
Tear Strength ⁷			ASTM D624
Transverse flow	15.2	kN/m	ASTM D624
Flow	14.7	kN/m	ASTM D624
Compression Set ⁸ (23°C, 22 hr)	12	%	ASTM D395B
Additional Information	Nominal Value		
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	138 - 188	°C	
Middle Temperature	154 - 199	°C	
Front Temperature	154 - 216	°C	
Nozzle Temperature	154 - 221	°C	
Processing (Melt) Temp	166 - 221	°C	
Mold Temperature	10.0 - 32.2	°C	
Injection Pressure	1.38 - 5.52	MPa	
Injection Rate	Moderate-Fast		
Back Pressure	0.172 - 0.689	MPa	
Screw Speed	50 - 100	rpm	
Cushion	3.81 - 25.4	mm	
Injection instructions			
Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).			
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	138 - 149	°C	
Cylinder Zone 2 Temp.	149 - 160	°C	
Cylinder Zone 3 Temp.	160 - 182	°C	
Cylinder Zone 5 Temp.	160 - 182	°C	
Die Temperature	160 - 182	°C	
Extrusion instructions			
Screw Speed: 30 to 100 rpm			
NOTE			

1.	Mouth die C, 510mm/min
2.	Mouth die C, 510mm/min
3.	C mold, 510mm/min
4.	C mold, 510mm/min
5.	C mold, 510mm/min
6.	Mouth die C, 510mm/min
7.	C mold, 510mm/min
8.	Type 1

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