

SANTOPRENE[®] 121-65M300

SANTOPRENE®

A soft, black, UV resistant thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material is designed for automotive interior applications requiring low fogging and good appearance. This grade of Santoprene® TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding. It is polyolefin based and recyclable within the manufacturing stream.

Key Features

- Designed for fast, easy injection molding, especially for complex part geometries
- Used in sealing applications
- Recommended for applications requiring superior part surface appearance
- Designed to be injected at lower molding temperatures or at lower injection pressures
- Designed for automotive interior applications requiring low fogging and low odor
- Designed for improved UV resistance

Product information

Resin Identification	TPV		ISO 1043
Part Marking Code	>TPV<		ISO 11469
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Typical mechanical properties			
Tensile stress at 100% elongation, perpendicular	2.3	MPa	ISO 37
Tensile stress at break, perpendicular	6.6	MPa	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular	490	%	ISO 527-1/-2 or ISO 37
Brittleness Temperature	-52	°C	ASTM D 746
Low temperature brittleness	-52	°C	ISO 812
Shore A hardness, 15s	65		ISO 48-4 / ISO 868
Compression set, 70°C, 24h	41	%	ISO 815
Flammability			
FMVSS Class	В		ISO 3795 (FMVSS 302)
Burning rate, Thickness 2 mm	43.9	mm/min	ISO 3795 (FMVSS 302)
Physical/Other properties			
Density	920	kg/m³	ISO 1183
Injection			
-			
Drying Recommended	yes		
Drying Temperature		°C	
Drying Time, Dehumidified Dryer	≥3		
Processing Moisture Content	≤0.08		
Melt Temperature Optimum	190		
Min. melt temperature	180		
Max. melt temperature	230		
Mold Temperature Optimum		°C	
Min. mould temperature		°C	
Max. mould temperature	60	°C	

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Characteristics

Processing	Injection Moulding, Multi Injection Moulding
Delivery form	Pellets
Special characteristics	U.V. stabilised or stable to weather, High Flow

Additional information

Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength	100°C, 1008h	-3	%	ISO 188
Change in Tensile Strain at Break	100°C, 1008h	-10	%	ISO 188
Change in Shore A Hardness	100°C, 1008h	2	-	ISO 188

Injection molding

Holding pressure should be about 50 to 75% of the actual injection pressure. A high screw RPM (100 to 200) is recommended.

Back pressure is not always needed, however, a back pressure of 0.3 to 0.7 MPa may be used to ensure a homogeneous melt and maintain a consistent shot size. A higher back pressure is normally employed when using masterbatches.

Processing Notes

Desiccant drying for 3 hours at 80 °C (180 °F) is recommended. Santoprene® TPV has a wide temperature processing window from 175 to 230 °C (350 to 450 °F) and is incompatible with acetal and PVC.

Santoprene® TPV has a relatively high melt viscosity at low shear rates. Viscosity decreases as the shear rate increases.

Increasing temperature has little effect on TPV melt viscosity. Smaller gates and higher shear rates keep melt viscosity low and improve melt flow. Please also refer to the injection molding guide.

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Ford	WSS-M2D510-A6	
Geely	Q/JLY J7110166C-2024	

Processing Notes

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Mercedes-Benz Stellantis - Chrysler VW Group VW Group DBL5562 MS-AR-100 BMV2 VW 50123 VW 50180

Black

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