

# SANTOPRENE® 271-64

## SANTOPRENE®

A soft, colorable, specialty thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. It is designed for use in non fatty food contact applications. This grade of Santoprene® TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding, extrusion or blow molding. It is polyolefin based and recyclable within the manufacturing stream.

### Key Features

- This product, in principle, can be used in food contact applications in the USA (FDA). Migration or use limitations may apply.
- Certified by NSF to NSF/ANSI Standard 51: Food Equipment Materials - Plastics, materials and components used in food equipment.
- UL listed: file #QMFZ2.E80017, Plastics - Component; file #QMFZ8.E80017, Plastics Certified For Canada - Component.
- Recommended for applications requiring excellent flex fatigue resistance.

### Product information

Resin Identification	TPV	ISO 1043
Part Marking Code	>TPV<	ISO 11469

### Typical mechanical properties

Tensile stress at 100% elongation, perpendicular	2.6 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	-60 °C	ASTM D 746
Low temperature brittleness	-60 °C	ISO 812
Shore A hardness, 15s	69	ISO 48-4 / ISO 868
Compression set, 70 °C, 24h	18 %	ISO 815
Compression set, 125 °C, 70h	44 %	ISO 815

### Physical/Other properties

Density	970 kg/m <sup>3</sup>	ISO 1183
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### Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	≥3 h
Processing Moisture Content	≤0.08 %
Max. regrind level	20 %
Melt Temperature Optimum	210 °C
Min. melt temperature	190 °C
Max. melt temperature	230 °C
Mold Temperature Optimum	30 °C
Min. mould temperature	10 °C
Max. mould temperature	50 °C

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### Extrusion

Drying Temperature	82 °C
Drying Time, Dehumidified Dryer	3 h
Melt Temperature Range	196 °C

### Characteristics

Processing	Injection Moulding, Multi Injection Moulding, Extrusion, Sheet Extrusion, Coextrusion, Blow Moulding
Delivery form	Pellets

### Additional information

#### Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength	150 °C, 168h	-12	%	ISO 188
Change in Tensile Strain at Break	150 °C, 168h	6	%	ISO 188
Change in Shore A Hardness	150 °C, 168h	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

### 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.

# SANTOPRENE® 271-64

## SANTOPRENE®

Printed: 2025-05-30

Page: 3 of 3

Revised: 2025-04-21 Source: Celanese Materials Database

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