



# SANTOPRENE® 291-75B150

## **SANTOPRENE®**

Santoprene® 291-75B150 is a colorable, specialty thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. It is especially formulated to bond to PC, ABS, PC/ABS, ASA and PMMA for applications where hard/soft combinations are required. This grade of Santoprene® TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding or extrusion.

### **Key Features**

- · Designed for excellent adhesion to PC, ABS, PC/ABS, ASA and PMMA (cold insert or 2K [two-shot] molding).
- · Broad processing window in injection molding.
- · Recommended for applications requiring superior part surface appearance.
- · Designed for soft touch applications.
- · UL listed: file #QMFZ2.E80017, Plastics Component; file #QMFZ8.E80017, Plastics Certified For Canada Component.

#### Product information

1 Todact information		
Resin Identification	TPV	ISO 1043
Part Marking Code	>TPV<	ISO 11469
Typical mechanical properties		
Shore A hardness, 15s	78	ISO 48-4 / ISO 868
Compression set, 23°C, 24h	38 %	ISO 815
Compression set, 70°C, 24h	68 %	ISO 815
Physical/Other properties		
Density	1090 kg/m <sup>3</sup>	ISO 1183
Injection		
Drying Recommended	yes	
Drying Temperature	, 80 °C	
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Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	≥3 h
Processing Moisture Content	≤0.03 %
Melt Temperature Optimum	210 °C
Min. melt temperature	190 °C
Max. melt temperature	230 °C
Mold Temperature Optimum	40 °C
Min. mould temperature	30 °C
Max. mould temperature	50 °C

## Characteristics

Processing Injection Moulding, Multi Injection Moulding, Coextrusion

Delivery form Pellets

#### Additional information

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.

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A higher back pressure is normally employed when using masterbatches.

Processing Notes

### **Processing Notes**

Desiccant drying for 3 hours at  $80^{\circ}$ C ( $180^{\circ}$ F) is recommended. Santoprene® TPV has a wide temperature processing window from 175 to 230°C (350 to  $450^{\circ}$ 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 ADDITIONAL INFORMATION

General Motors Special Parts Approval, See Your CE Account

Representative for Further Details.

VW Group VW 50123

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