



SANTOPRENE® 6SD001A30 NAT SANTOPRENE®

Product information			
Resin Identification Part Marking Code	TPV >TPV<		ISO 1043 ISO 11469
Typical mechanical properties			
Tensile stress at 100% elongation, per Stress at 300% elongation Stress at break Elongation at break, perpendicular Shore A hardness, 15s Compression set, 70°C, 24h Tear strength, normal	1.5 1.9 422 28 27	MPa MPa % % kN/m	ISO 37 ISO 527-1/-2 or ISO 37 ISO 527-1/-2 or ISO 37 ISO 527-1/-2 or ISO 37 ISO 48-4 / ISO 868 ISO 815 ISO 34-1
Thermal properties			
Coefficient of linear thermal expansion	186 ^[1]	E-6/K	ISO 11359-1/-2
(CLTE), parallel Coefficient of linear thermal expansior normal [1]: Temperature range: -50°C to 120°C	n (CLTE), 329 ^[1]	E-6/K	ISO 11359-1/-2
Physical/Other properties			
Density	900	kg/m³	ISO 1183
Injection			
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Mold Temperature Optimum Min. mould temperature Max. mould temperature	≥3 ≤0.08 185 180 190 30 20	% °C °C	
Characteristics			
Processing	Injection Moulding		
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.		
	A higher back pressure is normal	y employea when using i	masierdatches.

Processing Notes

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Processing Notes

refer to the injection molding guide.

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

Storage

Santoprene must be stored indoors in the original, unopened and undamaged packaging, away from direct sunlight, moisture and heat.

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