



SANTOPRENE® 6SD001A65 NAT

SANTOPRENE®

Product information

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

Typical mechanical properties

Tensile stress at 100% elongation, perpendicular	2.1 MPa	a ISO 37
Stress at 300% elongation	3.4 MPa	a ISO 527-1/-2 or ISO 37
Stress at break	5.4 MPa	a ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular	562 %	ISO 527-1/-2 or ISO 37
Shore A hardness, 15s	64	ISO 48-4 / ISO 868
Compression set, 70°C, 24h	42 %	ISO 815
Tear strength, normal	26 kN/r	m ISO 34-1

Physical/Other properties

Density 918 kg/m³ ISO 1183

Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	≥3 h
Processing Moisture Content	≤0.08 %
Melt Temperature Optimum	200 °C
Min. melt temperature	195 °C
Max. melt temperature	205 °C
Mold Temperature Optimum	30 °C
Min. mould temperature	20 °C
Max. mould temperature	40 °C

Characteristics

Processing Injection Moulding

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. 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

Printed: 2025-05-30 Page: 1 of 2

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





SANTOPRENE® 6SD001A65 NAT SANTOPRENE®

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.

Storage

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

Printed: 2025-05-30 Page: 2 of 2

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

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users

© 2025 Celanese or its affiliates. All rights reserved. Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC.