



SANTOPRENE® 6SD002A87 NAT **SANTOPRENE®**

Product information				
Resin Identification		TPV		ISO 1043
Part Marking Code		>TPV<		ISO 11469
Typical mechanical properties				
Tensile stress at 100% elongation, pe	erpendicular	4.9	MPa	ISO 37
Stress at 300% elongation		6	MPa	ISO 527-1/-2 or ISO 37
Stress at break		7.8	MPa	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular		538	%	ISO 527-1/-2 or ISO 37
Shore A hardness, 15s		91		ISO 48-4 / ISO 868
Compression set, 70°C, 24h		70	%	ISO 815
Tear strength, normal		55	kN/m	ISO 34-1
Physical/Other properties				
Density		958	kg/m³	ISO 1183
Injection				
Drying Recommended		yes		
Drying Temperature			°C	
Drying Time, Dehumidified Dryer		≥3	h	
Processing Moisture Content		≤0.08	%	
Melt Temperature Optimum		210	°C	
Min. melt temperature		205	°C	
Max. melt temperature		215	°C	
Mold Temperature Optimum		30	°C	
Min. mould temperature		20	°C	
Max. mould temperature		40	°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 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.

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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.

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