

SANTOPRENE[®] 8211-35

SANTOPRENE®

A soft, colorable, non-hygroscopic thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material combines good physical properties and chemical resistance for use in difficult injection molding applications. This grade of Santoprene® TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding. It is polyolefin based and recyclable within the manufacturing stream.

Key Features

- · Non-hygroscopic product, requires little to no drying before processing.
- · Neutral, easy coloring formulation.
- · Excellent ozone resistance.
- Used in sealing applications.
- · Recommended for applications requiring excellent flex fatigue resistance.

Product information Resin Identification Part Marking Code	TPV >TPV<		ISO 1043 ISO 11469
Typical mechanical properties			
Tensile stress at 100% elongation, perpendicular Tensile stress at break, perpendicular Elongation at break, perpendicular Brittleness Temperature Low temperature brittleness Shore A hardness, 15s Compression set, 23°C, 24h Compression set, 125°C, 70h		°C °C %	ISO 37 ISO 527-1/-2 or ISO 37 ISO 527-1/-2 or ISO 37 ASTM D 746 ISO 812 ISO 48-4 / ISO 868 ISO 815 ISO 815
Flammability			
FMVSS Class Burning rate, Thickness 2 mm	B 34.1	mm/min	ISO 3795 (FMVSS 302) ISO 3795 (FMVSS 302)
Physical/Other properties			
Density	930	kg/m³	ISO 1183
Injection			
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Max. regrind level Melt Temperature Optimum Min. melt temperature Max. melt temperature Mold Temperature Optimum Min. mould temperature	≥3 ≤0.08 20 200 185 215 35 20	% % °C °C °C °C	
Max. mould temperature	50	°C	

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Characteristics

Processing	Injection Moulding, Multi Injection Moulding
Delivery form	Pellets
Special characteristics	High Flow

Additional information

Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength	150°C, 168h	-21	%	ISO 188
Change in Tensile Strain at Break	150°C, 168h	-18	%	ISO 188
Change in Shore A Hardness	150°C, 168h	3	-	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 $80 \degree C$ ($180 \degree F$) 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 refer to the injection molding guide.

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	Special Parts Approval, See Your CE Account Representative for Further Details.	

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Mercedes-Benz Stellantis - Chrysler VW Group DBL5562 MS-AR-100 AMN VW 50123

Natural

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