

## SANTOPRENE® 8221-75M300

**SANTOPRENE®** 

A soft, colorable, UV resistant thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material is designed for automotive interior applications requiring low fogging and good appearance. 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**

- Neutral, easy coloring formulation.
- · Recommended for applications requiring excellent ozone resistance.
- Used in sealing applications.
- · Recommended for applications requiring excellent flex fatigue resistance.
- · Designed for improved UV resistance.

Product information			
Resin Identification Part Marking Code	TPV >TPV<		ISO 1043 ISO 11469
Rheological properties			
Moulding shrinkage, parallel	1.6 <sup>[1]</sup> 0.9 <sup>[1]</sup>		ISO 294-4, 2577
Moulding shrinkage, normal [1]: 2.0 mm thickness, min. 24 hours after molding, per test m		%	ISO 294-4, 2577
Typical mechanical properties			
Tensile stress at 100% elongation, perpendicular	-	MPa	ISO 37
Tensile stress at break, perpendicular		MPa	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular Shore A hardness, 15s	490 75	%	ISO 527-1/-2 or ISO 37 ISO 48-4 / ISO 868
Shore A hardness, 13s	15		130 48-47 130 888
Flammability			
FMVSS Class	В		ISO 3795 (FMVSS 302)
Burning rate, Thickness 2 mm	17.3	mm/min	ISO 3795 (FMVSS 302)
Physical/Other properties			
Density	920	kg/m³	ISO 1183
Injection			
Drying Recommended	yes		
Drying Temperature		°C	
Drying Time, Dehumidified Dryer	≥3		
Processing Moisture Content	≤0.08		
Melt Temperature Optimum Min. melt temperature	200 190		
Max. melt temperature	215		
Mold Temperature Optimum		°C	
Min. mould temperature		°C	
Max. mould temperature	50	°C	

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## **Characteristics** Processing Injection Moulding, Multi Injection Moulding Pellets Delivery form Special characteristics U.V. stabilised or stable to weather, High Flow 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. 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 Ford WSS-M2D510-A7 **General Motors** GMW15816P-TPV-EPDM+PP-Class-I-Type-6 Mercedes-Benz DBL5562 Stellantis 55248 02 EMP80 MS-AR-100 CMV2

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