



# SANTOPRENE® 8223-30M300

## **SANTOPRENE®**

A hard, 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<sup>TM</sup> 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	TPV	ISO 1043
Part Marking Code	>TPV<	ISO 11469
Typical mechanical properties		
71		

5.3 MPa	18037
9.3 MPa	ISO 527-1/-2 or ISO 37
490 %	ISO 527-1/-2 or ISO 37
26	ISO 48-4 / ISO 868
	9.3 MPa 490 %

#### Physical/Other properties

Density 920 kg/m<sup>3</sup> 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	185 °C
Max. melt temperature	215 °C
Mold Temperature Optimum	35 °C
Min. mould temperature	20 °C
Max. mould temperature	50 °C

## Characteristics

Processing Injection Moulding, Multi Injection Moulding

Delivery form Pellets

Special characteristics U.V. stabilised or stable to weather, High Flow

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#### 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 VW Group VW 50123

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