

SANTOPRENE® 9101-80E

SANTOPRENE®

A black thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material is designed for coextrusion applications, particularly for the static foot of automotive weatherseal systems like glass run channels. This grade of Santoprene™ TPV is shear-dependent and can be processed on conventional thermoplastics equipment for extrusion or thermoforming. It is polyolefin based and recyclable within the manufacturing stream.

Key Features

- Recommended for coextruded applications not exposed to UV light.
- Recommended for applications requiring excellent ozone resistance.
- Designed to maximize run length with minimal build-up of material on screen packs or narrow sections of dies.

Product information

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

Typical mechanical properties

Tensile stress at 100% elongation, perpendicular	3.4 MPa	ISO 37
Tensile stress at break, perpendicular	7 MPa	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular	670 %	ISO 527-1/-2 or ISO 37
Shore A hardness, 15s	80	ISO 48-4 / ISO 868
Compression set, 70 °C, 24h	48 %	ISO 815

Physical/Other properties

Density	970 kg/m ³	ISO 1183
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Extrusion

Drying Temperature	82 °C
Drying Time, Dehumidified Dryer	3 h
Melt Temperature Range	177 - 204 °C

Characteristics

Processing	Coextrusion, Thermoforming
Delivery form	Pellets

Additional information

Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength	150 °C, 168h	-24.9	%	ISO 188
Change in Tensile Strain at Break	150 °C, 168h	-23.4	%	ISO 188
Change in Shore A	150 °C, 168h	1	-	ISO 188

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Hardness				

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. Do not exceed 15% drawdown.

Automotive

OEM

SAIC Motor

Stellantis

VW Group

VW Group

STANDARD

SMTC 5 320 024

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VW 50123

VW TL 527 03