SANTOPRENE™ 211-45 - TPV

Product Description

A soft, colorable, versatile thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material combines good physical properties and chemical resistance for use in a wide range of 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.

Characteristics

Applications	Automotive - Grips, Automotive - Interior Mat, Industrial - Seals and Gaskets, Soft Touch Grips, Tubing
Uses	Automotive applications, Gaskets, Seals
Agency Ratings	UL QMFZ2, UL QMFZ8
UL File Number	E80017
Color	Natural color
Delivery Form	Pellets
Processing	Injection molding, Multi injection molding

Physical properties	Value	Unit	Test Standard
Density	**0.96**	g/cm³	ASTM D792
Density	**960**	kg/m³	ISO 1183

Hardness	Value	Unit	
Shore A hardness-TPE, 15s	**49**		ISO 868

Mechanical properties	Value	Unit	Test Standard
Tensile stress at 100%, perpendicular	**1.4**	MPa	ASTM D412
Tensile stress at 100%, perpendicular	**1.4**	MPa	ISO 37
Tensile strength at break elast, perpendicular	**3.5**	MPa	ASTM D412
Tensile stress at break, perpendicular	**3.5**	MPa	ISO 37
Elongation at break elast, perpendicular	**340**	%	ASTM D412
Tensile strain at break, perpendicular	**340**	%	ISO 37
Compression set, 23°C, 22h, Type 1, Method B	**11**	%	ASTM D395
Compression set, 23°C, 22h, Type A	**11**	%	ISO 815
Compression set, 125°C, 70h, Type 1, Method B	**35**	%	ASTM D395
Compression set, 125°C, 70h, Type A	**35**	%	ISO 815

Thermal properties	Value	Unit	Test Standard
Brittleness temperature	**-62**	°C	ASTM D746
RTI Elec	**100**	°C	UL 746
RTI Str, 1.0 mm	**90**	°C	UL 746
RTI Str, 3.0 mm	**95**	°C	UL 746

Electrical properties	Value	Unit	Test Standard
Dielectric Strength, 2.0 mm	**30**	kV/mm	ASTM D149
Dielectric Constant, 60Hz, 2.03 mm	**2.4**	-	ASTM D150
Dielectric Constant 60Hz, 2.03 mm	**2.4**	-	IEC 60250

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Injection	Value	Unit
Drying temperature	**82**	°C
Drying time	**3**	h
Necessary low maximum residual moisture content	**0.08**	%
Suggested maximum regrind	**20**	%
Rear temperature	**177 - 193**	°C
Middle temperature	**179 - 199**	°C
Front temperature	**179 - 204**	°C
Nozzle temperature	**191 - 229**	°C
Melt temperature	**193 - 241**	°C
Mold temperature	**10 - 52**	°C
Injection speed	**fast**	-
Back pressure	**0.345 - 0.689**	MPa
Screw Speed	**100 - 200**	RPM
Clamp tonnage	**41 - 69**	MPa
Cushion	**3.18 - 6.35**	mm
Screw L/D	**20:1/***	-
Screw compression ratio	**2.5:1/***	-
Vent depth	**0.025**	mm

Aging	Value	Unit	Test Standard
Change in Tensile Strength in Air @ 150 C, 168 h	**-23**	%	ASTM D573
Change in Tensile Strength in Air @ 150 C, 168 h	**-23**	%	ISO 188
Change in Ultimate Elongation in Air @ 150 C, 168 h	**26**	%	ASTM D573
Change in Tensile Strain at Break in Air @ 150 C, 168 h	**26**	%	ISO 188
Change in Durometer Hardness in Air @ 150 C, 168 h, Shore A	**1**	-	ASTM D573
Change in Shore Hardness in Air @ 150 C, 168 h, Shore A	**1**	-	ISO 188

Flammability	Value	Unit	
Flame rating, 1.0 mm	**HB**		UL 94
Flame rating, 3.0 mm	**HB**		UL 94

Other text information

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. An SPI/SPE #3 finish is recommended (do not polish).

Other Approvals

OEM	Specification
Chrysler (FCA)	MS-AR-100 BMN
FORD	WSD-M2D378-A4

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