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Santoprene™ 8211-35

Thermoplastic Vulcanizate

Product Description

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.

General

Availability [1]	▪ Africa & Middle East ▪ Asia Pacific	▪ Europe ▪ Latin America	▪ North America
Applications	▪ Automotive - Grips ▪ Automotive - HVAC Flapper Door Seals ▪ Automotive - Interior	▪ Automotive - Interior Mat ▪ Consumer Applications ▪ Seals and Gaskets	▪ Soft Touch Grips
Uses	▪ Automotive Applications ▪ Cell Phones	▪ Consumer Applications ▪ Flexible Grips	▪ Seals
RoHS Compliance	▪ RoHS Compliant		
Automotive Specifications	▪ CHRYSLER MS-AR-100 AMN	▪ GM GMP.E/P.083	
Color	▪ Natural Color		
Form(s)	▪ Pellets		
Processing Method	▪ Injection Molding	▪ Multi Injection Molding	
Revision Date	▪ 06/20/2014		

Physical	Typical Value (English)		Typical Value (SI)		Test Based On
Density / Specific Gravity	0.930		0.930		ASTM D792
Density	0.930	g/cm³	0.930	g/cm³	ISO 1183

Hardness	Typical Value (English)		Typical Value (SI)		Test Based On
Shore Hardness					ISO 868
Shore A, 15 sec, 73°F (23°C)	38		38		

Elastomers	Typical Value (English)		Typical Value (SI)		Test Based On
Tensile Stress at 100% - Across Flow (73°F (23°C))	145	psi	1.00	MPa	ASTM D412
Tensile Stress at 100% - Across Flow (73°F (23°C))	145	psi	1.00	MPa	ISO 37
Tensile Strength at Break - Across Flow (73°F (23°C))	421	psi	2.90	MPa	ASTM D412
Tensile Stress at Break - Across Flow (73°F (23°C))	421	psi	2.90	MPa	ISO 37
Elongation at Break - Across Flow (73°F (23°C))	350	%	350	%	ASTM D412
Tensile Strain at Break - Across Flow (73°F (23°C))	350	%	350	%	ISO 37
Compression Set					ASTM D395B
73°F (23°C), 22 hr, Type 1	10	%	10	%	
257°F (125°C), 70 hr, Type 1	36	%	36	%	
Compression Set					ISO 815
73°F (23°C), 22 hr, Type A	10	%	10	%	
257°F (125°C), 70 hr, Type A	36	%	36	%	

Thermal	Typical Value (English)		Typical Value (SI)		Test Based On
Brittleness Temperature	-85	°F	-65	°C	ASTM D746
Brittleness Temperature	-85	°F	-65	°C	ISO 812

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Injection	Typical Value (English)		Typical Value (SI)	
Suggested Max Moisture	0.080	%	0.080	%
Suggested Max Regrind	20	%	20	%
Rear Temperature	350 to 375	°F	177 to 191	°C
Middle Temperature	355 to 380	°F	179 to 193	°C
Front Temperature	365 to 390	°F	185 to 199	°C
Nozzle Temperature	365 to 410	°F	185 to 210	°C
Processing (Melt) Temp	290 to 420	°F	143 to 216	°C
Mold Temperature	75 to 125	°F	24 to 52	°C
Injection Rate	Fast		Fast	
Back Pressure	50.0 to 100	psi	0.345 to 0.689	MPa
Screw Speed	100 to 200	rpm	100 to 200	rpm
Clamp Tonnage	3.0 to 5.0	tons/in^2	41 to 69	MPa
Cushion	0.125 to 0.250	in	3.18 to 6.35	mm
Screw L/D Ratio	16.0:1.0 to 20.0:1.0		16.0:1.0 to 20.0:1.0	
Screw Compression Ratio	2.0:1.0 to 2.5:1.0		2.0:1.0 to 2.5:1.0	
Vent Depth	1.0E-3	in	0.025	mm

Injection Notes

Santoprene™ TPV is incompatible with acetal and PVC. For more information regarding processing and mold design, please consult our Injection Molding Guide.

Aging	Typical Value (English)		Typical Value (SI)		Test Based On
Change in Tensile Strength in Air					ASTM D573
302°F (150°C), 168 hr	-21	%	-21	%	
Change in Tensile Strength in Air					ISO 188
302°F (150°C), 168 hr	-21	%	-21	%	
Change in Ultimate Elongation in Air					ASTM D573
302°F (150°C), 168 hr	-18	%	-18	%	
Change in Tensile Strain at Break in Air					ISO 188
302°F (150°C), 168 hr	-18	%	-18	%	
Change in Durometer Hardness in Air					ASTM D573
Shore A, 302°F (150°C), 168 hr	3.0		3.0		
Change in Shore Hardness in Air					ISO 188
Shore A, 302°F (150°C), 168 hr	3.0		3.0		

Additional Information

Where applicable, test results based on fan gated, 2.0 mm injection molded plaques. Tensile strength, elongation and tensile stress are measured across the flow direction. All ASTM and ISO methods shown may be modified by the ExxonMobil laboratory. Test methods are available upon request. Compression set at 25% deflection. All products purchased directly from an ExxonMobil affiliate in Europe are REACH compliant. For products not imported into Europe by ExxonMobil, customers should assess their legal responsibilities under REACH.

Legal Statement

This product, including the product name, shall not be used or tested in any medical application without the prior written acknowledgement of ExxonMobil Chemical as to the intended use. For detailed Product Stewardship information, please contact Customer Service.

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Processing Statement

Desiccant drying for 3 hours at 80°C (180°F) can be performed if desired. Santoprene TPV has a wide temperature processing window from 175 to 230°C (350 to 450°F) and is incompatible with acetal and PVC. For more information, please consult our Safety Data Sheet and Injection Molding Guide.

Notes

Typical properties: these are not to be construed as specifications.

[1] Product may not be available in one or more countries in the identified Availability regions. Please contact your Sales Representative for complete Country Availability.

For additional technical, sales and order assistance: www.exxonmobilchemical.com/ContactUs

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