



**Product Data Sheet &  
General Processing Conditions**

**Permaprene™ 2840 B-85A  
Thermoplastic Elastomer Alloy  
TPV Alloy**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.12	1.12	D 792
<b>MECHANICAL</b>			
Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	1100 psi	8 MPa	D 412
Tensile Elongation Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	800.0 %	800.0 %	D 412
Tensile Stress Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min) @ 100 %	450.0 psi	3.1 MPa	D 412
Tear Strength, Die C	210.0 pli	36.8 N/mm	D 624
Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2	40 %	40 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	72 %	72 %	D 395
Hardness Shore A, 10 s delay	85	85	D 2240

**PROPERTY NOTES**

Data herein is typical and not to be construed as specifications.  
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Melt Temperature	360 - 410 °F	182 - 210 °C
Mold Temperature	60 - 120 °F	16 - 49 °C
Drying	2 hrs @ 175 °F	2 hrs @ 79 °C
Moisture Content	< 0.05 %	< 0.05 %