

# SANTOPRENE® 8211-35

## SANTOPRENE®

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.

### Product information

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

### Typical mechanical properties

Tensile stress at 100% elongation, perpendicular	1 MPa	ISO 37
Tensile stress at break, perpendicular	2.9 MPa	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular	350 %	ISO 527-1/-2 or ISO 37
Brittleness Temperature	-65 °C	ASTM D 746
Low temperature brittleness	-65 °C	ISO 812
Shore A hardness, 15s	38	ISO 48-4 / ISO 868
Compression set, 23 °C, 24h	10 %	ISO 815
Compression set, 125 °C, 70h	36 %	ISO 815

### Flammability

FMVSS Class	B	ISO 3795 (FMVSS 302)
Burning rate, Thickness 2 mm	34.1 mm/min	ISO 3795 (FMVSS 302)

### Physical/Other properties

Density	930 kg/m <sup>3</sup>	ISO 1183
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### Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	≥3 h
Processing Moisture Content	≤0.08 %
Max. regrind level	20 %
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

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### Characteristics

Processing	Injection Moulding, Multi Injection Moulding
Delivery form	Pellets
Special characteristics	High Flow

### Additional information

#### Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength	150 °C, 168h	-21	%	ISO 188
Change in Tensile Strain at Break	150 °C, 168h	-18	%	ISO 188
Change in Shore A Hardness	150 °C, 168h	3	-	ISO 188

#### 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  
General Motors

STANDARD  
Special Parts Approval, See Your CE Account Representative for Further Details.

ADDITIONAL INFORMATION

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## SANTOPRENE®

Mercedes-Benz

DBL5562

Stellantis - Chrysler

MS-AR-100 AMN

Natural

VW Group

VW 50123