

# Santoprene™ 101-73

## Thermoplastic Vulcanizate

Product Description	Key Features
A soft, black, 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 applications. This grade of Santoprene TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding, extrusion, blow molding, thermoforming or vacuum forming. It is polyolefin based and recyclable within the manufacturing stream.	<ul style="list-style-type: none"> <li>UL listed: file #QMFZ2.E80017, Plastics - Component; file #QMFZ8.E80017, Plastics Certified For Canada - Component.</li> <li>Recommended for applications requiring excellent flex fatigue resistance.</li> <li>Excellent ozone resistance.</li> </ul>

General			
Availability <sup>1</sup>	<ul style="list-style-type: none"> <li>Africa &amp; Middle East</li> <li>Asia Pacific</li> </ul>	<ul style="list-style-type: none"> <li>Europe</li> <li>Latin America</li> </ul>	<ul style="list-style-type: none"> <li>North America</li> </ul>
Applications	<ul style="list-style-type: none"> <li>Appliance - Feet</li> <li>Automotive - Air Induction System Ducts</li> <li>Automotive - Boots and Bellows for Steering and Suspension</li> <li>Automotive - Plugs, Bumpers, Grommets, Clips</li> <li>Automotive - Seals and Gaskets</li> <li>Automotive - Washer Tubes</li> <li>Consumer - Electronics</li> <li>Consumer - Feet</li> <li>Consumer - Speaker Surrounds</li> <li>Industrial - Seals and Gaskets</li> <li>Tubing</li> </ul>		
Uses	<ul style="list-style-type: none"> <li>Appliance Components</li> <li>Automotive Applications</li> <li>Automotive Under the Hood</li> <li>Consumer Applications</li> </ul>	<ul style="list-style-type: none"> <li>Diaphragms</li> <li>Electrical Parts</li> <li>Gaskets</li> <li>Outdoor Applications</li> </ul>	<ul style="list-style-type: none"> <li>Seals</li> <li>Tubing</li> </ul>
Agency Ratings	<ul style="list-style-type: none"> <li>UL QMFZ2</li> </ul>	<ul style="list-style-type: none"> <li>UL QMFZ8</li> </ul>	
RoHS Compliance	<ul style="list-style-type: none"> <li>RoHS Compliant</li> </ul>		
Automotive Specifications	<ul style="list-style-type: none"> <li>CHRYSLER MS-AR-100 CGN</li> </ul>	<ul style="list-style-type: none"> <li>FORD WSD-M2D380-A1</li> </ul>	<ul style="list-style-type: none"> <li>GM GMW15813 Type 6</li> </ul>
UL File Number	<ul style="list-style-type: none"> <li>E80017</li> </ul>		
Color	<ul style="list-style-type: none"> <li>Black</li> </ul>		
Form(s)	<ul style="list-style-type: none"> <li>Pellets</li> </ul>		
Processing Method	<ul style="list-style-type: none"> <li>Blow Molding</li> <li>Coextrusion</li> <li>Extrusion</li> <li>Extrusion Blow Molding</li> </ul>	<ul style="list-style-type: none"> <li>Injection Blow Molding</li> <li>Injection Molding</li> <li>Multi Injection Molding</li> <li>Profile Extrusion</li> </ul>	<ul style="list-style-type: none"> <li>Sheet Extrusion</li> <li>Thermoforming</li> <li>Vacuum Forming</li> </ul>
Revision Date	<ul style="list-style-type: none"> <li>04/01/2017</li> </ul>		

Physical	Typical Value (English)	Typical Value (SI)	Test Based On
Density / Specific Gravity	0.970	0.970	ASTM D792
Density	0.970 g/cm <sup>3</sup>	0.970 g/cm <sup>3</sup>	ISO 1183
Outdoor Suitability	f1	f1	UL 746C
Detergent Resistance	f3	f3	UL 749
Detergent Resistance	f4	f4	UL 2157

Hardness	Typical Value (English)	Typical Value (SI)	Test Based On
Shore Hardness			ISO 868
Shore A, 15 sec, 73°F (23°C)	78	78	

Santoprene™ 101-73  
Thermoplastic Vulcanizate

Elastomers	Typical Value (English)	Typical Value (SI)	Test Based On
Tensile Stress at 100% - Across Flow (73°F (23°C))	499 psi	3.44 MPa	ASTM D412
Tensile Stress at 100% - Across Flow (73°F (23°C))	499 psi	3.44 MPa	ISO 37
Tensile Strength at Break - Across Flow (73°F (23°C))	1160 psi	7.98 MPa	ASTM D412
Tensile Stress at Break - Across Flow (73°F (23°C))	1160 psi	7.98 MPa	ISO 37
Elongation at Break - Across Flow (73°F (23°C))	480 %	480 %	ASTM D412
Tensile Strain at Break - Across Flow (73°F (23°C))	480 %	480 %	ISO 37
Tear Strength - Across Flow 73°F (23°C), Method Ba, Angle (Unnicked)	143 lbf/in	25.0 kN/m	ISO 34-1
Compression Set 158°F (70°C), 22 hr, Type 1 257°F (125°C), 70 hr, Type 1	27 % 41 %	27 % 41 %	ASTM D395B
Compression Set 158°F (70°C), 22 hr, Type A 257°F (125°C), 70 hr, Type A	27 % 41 %	27 % 41 %	ISO 815
Thermal	Typical Value (English)	Typical Value (SI)	Test Based On
Brittleness Temperature	-76 °F	-60 °C	ASTM D746
Brittleness Temperature	-76 °F	-60 °C	ISO 812
RTI Elec	194 °F	90.0 °C	UL 746
RTI Str			UL 746
0.04 in (1.0 mm)	194 °F	90.0 °C	
0.06 in (1.5 mm)	194 °F	90.0 °C	
0.12 in (3.0 mm)	203 °F	95.0 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Based On
Dielectric Strength 73°F (23°C), 0.0787 in (2.00 mm)	680 V/mil	27 kV/mm	ASTM D149
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.50	2.50	ASTM D150
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.50	2.50	IEC 60250
Comparative Tracking Index (CTI)	PLC 0	PLC 0	UL 746
High Amp Arc Ignition (HAI)	PLC 0	PLC 0	UL 746
High Voltage Arc Resistance to Ignition (HVAR)	PLC 6	PLC 6	UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 1	PLC 1	UL 746
Hot-wire Ignition (HWI)			UL 746
0.04 in (1.0 mm)	PLC 4	PLC 4	
0.06 in (1.5 mm)	PLC 3	PLC 3	
0.12 in (3.0 mm)	PLC 3	PLC 3	

## Santoprene™ 101-73

### Thermoplastic Vulcanizate

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	3.0 hr	3.0 hr
Suggested Max Moisture	0.080 %	0.080 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	350 °F	177 °C
Middle Temperature	360 °F	182 °C
Front Temperature	370 °F	188 °C
Nozzle Temperature	380 to 440 °F	193 to 227 °C
Processing (Melt) Temp	390 to 450 °F	199 to 232 °C
Mold Temperature	50 to 125 °F	10 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 <sup>2</sup>	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.

Extrusion	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	3.0 hr	3.0 hr
Melt Temperature	395 °F	202 °C
Die Temperature	400 °F	204 °C
Back Pressure	725 to 2900 psi	5.00 to 20.0 MPa

#### Extrusion Notes

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

Aging	Typical Value (English)	Typical Value (SI)	Test Based On
Change in Tensile Strength in Air 302°F (150°C), 168 hr	-8.0 %	-8.0 %	ASTM D573
Change in Tensile Strength in Air 302°F (150°C), 168 hr	-8.0 %	-8.0 %	ISO 188
Change in Ultimate Elongation in Air 302°F (150°C), 168 hr	-9.4 %	-9.4 %	ASTM D573
Change in Tensile Strain at Break in Air 302°F (150°C), 168 hr	-9.4 %	-9.4 %	ISO 188
Change in Durometer Hardness in Air Shore A, 302°F (150°C), 168 hr	1.7	1.7	ASTM D573
Change in Shore Hardness in Air Shore A, 302°F (150°C), 168 hr	1.7	1.7	ISO 188
Continuous Upper Temperature Resistance 1008 hr	275 °F	135 °C	SAE J2236

Flammability	Typical Value (English)	Typical Value (SI)	Test Based On
Flame Rating			UL 94
0.04 in (1.0 mm)	HB	HB	
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

## Santoprene™ 101-73

### Thermoplastic Vulcanizate

#### 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. Test results are generated by ExxonMobil test methods that may not fully conform to the ASTM and/or ISO methods. 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

For detailed Product Stewardship information, please contact Customer Service.

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.

#### Processing Statement

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. For more information, please consult our Safety Data Sheet, Injection Molding Guide and Extrusion Guide.

#### Notes

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

<sup>1</sup> 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](http://www.exxonmobilchemical.com/ContactUs)

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