

Santoprene™ 121-87

Thermoplastic Vulcanizate

Product Description	Key Features
A hard, black, UV resistant 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"> Recommended for applications requiring excellent flex fatigue resistance. Excellent ozone resistance. Designed for improved UV resistance.

General	
Availability ¹	<ul style="list-style-type: none"> Africa & Middle East Asia Pacific Europe Latin America North America
Applications	<ul style="list-style-type: none"> Automotive - Interior Mat Automotive - Seals and Gaskets Automotive - Weather Seals
Uses	<ul style="list-style-type: none"> Automotive Applications Automotive Interior Trim Automotive Exterior Trim Outdoor Applications
RoHS Compliance	<ul style="list-style-type: none"> RoHS Compliant
Automotive Specifications	<ul style="list-style-type: none"> CHRYSLER MS-AR-100 EGV FORD WSS-M2D382-B1 GM GMW15812, Type 8E
Color	<ul style="list-style-type: none"> Black
Form(s)	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Blow Molding Coextrusion Extrusion Extrusion Blow Molding Injection Blow Molding Injection Molding Multi Injection Molding Profile Extrusion Sheet Extrusion Thermoforming Vacuum Forming
Revision Date	<ul style="list-style-type: none"> 06/20/2014

Physical	Typical Value (English)	Typical Value (SI)	Test Based On
Density / Specific Gravity	0.970	0.970	ASTM D792
Density	0.970 g/cm ³	0.970 g/cm ³	ISO 1183

Hardness	Typical Value (English)	Typical Value (SI)	Test Based On
Shore Hardness			ISO 868
Shore A, 15 sec, 73°F (23°C)	93	93	

Elastomers	Typical Value (English)	Typical Value (SI)	Test Based On
Tensile Stress at 100% - Across Flow (73°F (23°C))	986 psi	6.80 MPa	ASTM D412
Tensile Stress at 100% - Across Flow (73°F (23°C))	986 psi	6.80 MPa	ISO 37
Tensile Strength at Break - Across Flow (73°F (23°C))	2200 psi	15.2 MPa	ASTM D412
Tensile Stress at Break - Across Flow (73°F (23°C))	2200 psi	15.2 MPa	ISO 37
Elongation at Break - Across Flow (73°F (23°C))	600 %	600 %	ASTM D412
Tensile Strain at Break - Across Flow (73°F (23°C))	600 %	600 %	ISO 37
Compression Set			ASTM D395B
73°F (23°C), 22 hr, Type 1	28 %	28 %	
257°F (125°C), 70 hr, Type 1	65 %	65 %	
Compression Set			ISO 815
73°F (23°C), 22 hr, Type A	28 %	28 %	
257°F (125°C), 70 hr, Type A	65 %	65 %	

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Thermal	Typical Value (English)	Typical Value (SI)	Test Based On
Brittleness Temperature	-72 °F	-58 °C	ASTM D746
Brittleness Temperature	-72 °F	-58 °C	ISO 812

Electrical	Typical Value (English)	Typical Value (SI)	Test Based On
Dielectric Strength 73°F (23°C), 0.0787 in (2.00 mm)	670 V/mil	26 kV/mm	ASTM D149
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.70	2.70	ASTM D150
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.70	2.70	IEC 60250

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	360 °F	182 °C
Middle Temperature	370 °F	188 °C
Front Temperature	380 °F	193 °C
Nozzle Temperature	390 to 455 °F	199 to 235 °C
Processing (Melt) Temp	400 to 450 °F	204 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 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.

Extrusion	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	3.0 hr	3.0 hr
Melt Temperature	400 °F	204 °C
Die Temperature	410 °F	210 °C
Back Pressure	725 to 2900 psi	5.00 to 20.0 MPa

Extrusion Notes

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Aging	Typical Value (English)	Typical Value (SI)	Test Based On
Change in Tensile Strength in Air 275°F (135°C), 1008 hr	-3.0 %	-3.0 %	ASTM D573
Change in Tensile Strength in Air 275°F (135°C), 1008 hr	-3.0 %	-3.0 %	ISO 188
Change in Ultimate Elongation in Air 275°F (135°C), 1008 hr	-14 %	-14 %	ASTM D573
Change in Tensile Strain at Break in Air 275°F (135°C), 1008 hr	-14 %	-14 %	ISO 188
Change in Durometer Hardness in Air Shore A, 275°F (135°C), 1008 hr	1.0	1.0	ASTM D573
Change in Shore Hardness in Air Shore A, 275°F (135°C), 1008 hr	1.0	1.0	ISO 188
Continuous Upper Temperature Resistance 1008 hr	275 °F	135 °C	SAE J2236

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

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) 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.

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.

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