

Santoprene™ 271-80

Thermoplastic Vulcanizate

Product Description

A soft, colorable, specialty thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. It is designed for use in non fatty food contact 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.

Key Features

- This product, in principle, can be used in food contact applications in the USA (FDA). Migration or use limitations may apply.
- Certified by NSF to NSF/ANSI Standard 51: Food Equipment Materials - Plastics, materials and components used in food equipment.
- UL listed: file #QMFZ2.E80017, Plastics - Component; file #QMFZ8.E80017, Plastics Certified For Canada - Component.
- Recommended for applications requiring excellent flex fatigue resistance.

General

Availability ¹	▪ Africa & Middle East ▪ Asia Pacific	▪ Europe ▪ Latin America	▪ North America
Applications	▪ Consumer - FDA Seals and Closures ▪ Consumer - Packaging	▪ Consumer - Small Appliance ▪ Consumer - Soft Touch Grips	▪ Seals and Gaskets
Uses	▪ Filters ▪ Flexible Grips ▪ Food Containers ▪ Gaskets	▪ Kitchenware ▪ Living Hinges ▪ Non-specific Food Applications ▪ Seals	▪ Tubing ▪ White Goods & Small Appliances
Agency Ratings	▪ FDA Food Contact, Unspecified Rating ▪ NSF STD-51	▪ UL QMFZ2 ▪ UL QMFZ8	
RoHS Compliance	▪ RoHS Compliant		
UL File Number	▪ E80017		
Color	▪ Natural Color		
Form(s)	▪ Pellets		
Processing Method	▪ Blow Molding ▪ Coextrusion ▪ Extrusion ▪ Extrusion Blow Molding	▪ Injection Blow Molding ▪ Injection Molding ▪ Multi Injection Molding ▪ Profile Extrusion	▪ Sheet Extrusion ▪ Thermoforming ▪ Vacuum Forming
Revision Date	▪ 06/20/2014		

Physical	Typical Value (English)	Typical Value (SI)	Test Based On
Density / Specific Gravity	0.950	0.950	ASTM D792
Density	0.950 g/cm ³	0.950 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)	85	85	



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Elastomers	Typical Value (English)	Typical Value (SI)	Test Based On
Tensile Stress at 100% - Across Flow (73°F (23°C))	667 psi	4.60 MPa	ASTM D412
Tensile Stress at 100% - Across Flow (73°F (23°C))	667 psi	4.60 MPa	ISO 37
Tensile Strength at Break - Across Flow (73°F (23°C))	1540 psi	10.6 MPa	ASTM D412
Tensile Stress at Break - Across Flow (73°F (23°C))	1540 psi	10.6 MPa	ISO 37
Elongation at Break - Across Flow (73°F (23°C))	540 %	540 %	ASTM D412
Tensile Strain at Break - Across Flow (73°F (23°C))	540 %	540 %	ISO 37
Compression Set			ASTM D395B
158°F (70°C), 22 hr, Type 1	41 %	41 %	
257°F (125°C), 70 hr, Type 1	47 %	47 %	
Compression Set			ISO 815
158°F (70°C), 22 hr, Type A	41 %	41 %	
257°F (125°C), 70 hr, Type A	47 %	47 %	

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

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 450 °F	193 to 232 °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 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



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Extrusion Notes

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Aging	Typical Value (English)	Typical Value (SI)	Test Based On
Change in Tensile Strength in Air 302°F (150°C), 168 hr	-5.0 %	-5.0 %	ASTM D573
Change in Tensile Strength in Air 302°F (150°C), 168 hr	-5.0 %	-5.0 %	ISO 188
Change in Ultimate Elongation in Air 302°F (150°C), 168 hr	-12 %	-12 %	ASTM D573
Change in Tensile Strain at Break in Air 302°F (150°C), 168 hr	-12 %	-12 %	ISO 188
Change in Durometer Hardness in Air Shore A, 302°F (150°C), 168 hr	5.0	5.0	ASTM D573
Change in Shore Hardness in Air Shore A, 302°F (150°C), 168 hr	5.0	5.0	ISO 188

Additional Information

Where applicable, test results based on fan gated, injection molded plaques.

Tensile strength, elongation and tensile stress are measured across the flow direction - ISO type 1, ASTM die C.

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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