

Santoprene™ 8271-75

Thermoplastic Vulcanizate

ExxonMobil Chemical

Message:

It is a soft, colorable, special non-hygroscopic thermoplastic vulcanized elastomer (TPV) in the thermoplastic elastomer (TPE) series. It is suitable for non-fat food contact materials. This brand of Shanduping TPV is a shear rate dependent product that can be processed on conventional thermoplastic injection molding or blow molding equipment. This is a polyolefin-based material that can be recycled in the production process.

General Information	
UL YellowCard	E80017-250572
Features	Low friction coefficient
	Lower odor transfer
	Lower taste transfer
	Recyclable materials
	Good coloring
	Ozone resistance
	Good chemical resistance
	Compliance of Food Exposure
	Low or no water absorption
Uses	Kitchen utensils
	Large household appliances and small household appliances
	Non-specific food applications
	Active hinge
	Seals
	Soft handle
	Food container
Agency Ratings	FDA Food Exposure, Not Rated
	NSF 51
	UL QMFZ2
	UL QMFZ8
RoHS Compliance	RoHS compliance
UL File Number	E80017
Appearance	Natural color
Forms	Particle
Processing Method	Blow molding
	Multiple injection molding
	Extrusion blow molding
	Injection blowing molding

Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.938	g/cm ³	ASTM D792
--	0.940	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shaw A, 15 seconds, 23°C, 2.00mm)	81		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Across Flow (100% Strain, 23°C)	3.90	MPa	ASTM D412, ISO 37
Tensile Strength - Across Flow (Break, 23°C)	8.30	MPa	ASTM D412, ISO 37
Tensile Elongation - Across Flow (Break, 23°C)	480	%	ASTM D412, ISO 37
Tear Strength - Across Flow			
23°C ¹	26.0	kN/m	ASTM D624
23°C ²	26	kN/m	ISO 34-1
Compression Set			
70°C, 22 hr ³	37	%	ASTM D395B
125°C, 70 hr ⁴	75	%	ASTM D395B
70°C, 22 hr ⁵	37	%	ISO 815
125°C, 70 hr ⁶	75	%	ISO 815
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746, ISO 812
RTI Elec	100	°C	UL 746
RTI	85.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.10 mm	HB		UL 94
3.00 mm	HB		UL 94
Additional Information			
如果适用,这是基于扇形浇口注塑成型的平板测试结果.拉伸强度,伸长率和拉伸应力沿垂直流动方向测定 - ISO 1 型,ASTM die C.25% 形变时的永久压缩变形.从埃克森美孚欧洲分支机构直接购买的所有产品都符合 REACH 法规. 对于埃克森美孚未进口至欧洲的产品,用户应自行评估其是否满足 REACH 法规.			
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Injection	Nominal Value	Unit	
Suggested Max Moisture	0.080	%	
Suggested Max Regrind	20	%	
Rear Temperature	177 - 191	°C	
Middle Temperature	179 - 193	°C	
Front Temperature	185 - 199	°C	

Nozzle Temperature	185 - 210	°C
Processing (Melt) Temp	143 - 216	°C
Mold Temperature	23.9 - 51.7	°C
Injection Rate	Fast	
Back Pressure	0.345 - 0.689	MPa
Screw Speed	100 - 200	rpm
Clamp Tonnage	4.1 - 6.9	kN/cm ²
Cushion	3.18 - 6.35	mm
Screw L/D Ratio	16.0:1.0 to 20.0:1.0	
Screw Compression Ratio	2.0:1.0 to 2.5:1.0	
Vent Depth	0.025	mm

Injection instructions

Santoprene TPV与乙缩醛和PVC不相容.更多关于加工和模具设计的信息,请查阅我们的《注射成型指南》.

NOTE

1.	C mould
2.	Method B, right-angle specimen (cut)
3.	Type 1
4.	Type 1
5.	Type a
6.	Type a

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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