

Santoprene™ 121-79W233

Thermoplastic Vulcanizate

ExxonMobil Chemical

Message:

It is a soft, black thermoplastic vulcanized elastomer (TPV) in the thermoplastic elastomer (TPE) series. This material is specially formulated for bonding with sulfur or peroxide cured thermosetting EPDM rubber for corner injection molding, end caps and special fixing applications. This brand of Shanduping TPV is a shear rate dependent product that can be processed on conventional thermoplastic injection molding equipment. This is a polyolefin-based material that can be recycled in the production process.

General Information			
Features	Flexibility at low temperatures		
	Good UV resistance		
	Recyclable materials		
	Adhesiveness		
	Good adhesion		
	Ozone resistance		
	Good weather resistance		
Uses	Application in Automobile Field		
	Car exterior decoration		
	Outdoor application		
	Bonding		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Multiple injection molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.928	g/cm ³	ASTM D792
--	0.930	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shaw A, 15 seconds, 23°C, 2.00mm)	84		ISO 868
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress - Across Flow (100% Strain, 23°C)	3.60	MPa	ASTM D412, ISO 37
Tensile Strength - Across Flow (Break, 23°C)	7.40	MPa	ASTM D412, ISO 37

Tensile Elongation - Across Flow (Break, 23°C)	620	%	ASTM D412, ISO 37
Tear Strength - Across Flow			
23°C ¹	36.0	kN/m	ASTM D624
23°C ²	36	kN/m	ISO 34-1
Compression Set			
70°C, 22 hr ³	49	%	ASTM D395B
70°C, 22 hr ⁴	49	%	ISO 815
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air (100°C, 70 hr)	-4.0	%	ASTM D573, ISO 188
Change in Ultimate Elongation in Air (100°C, 70 hr)	-1.0	%	ASTM D573, ISO 188
Change in Durometer Hardness in Air (Shore A, 100°C, 70 hr)	-1.0		ASTM D573, ISO 188
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746, ISO 812
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	
Drying Temperature	82.2	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.080	%	
Suggested Max Regrind	20	%	
Mold Temperature	10.0 - 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》和《EPDM门窗密封条转角和端盖的注射成型》技术文献.			
NOTE			
1.	C mould		
2.	Method B, right-angle specimen (cut)		
3.	Type 1		

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