

# Viprene™ P85A-22U-BLK

Thermoplastic Vulcanizate  
Alliance Polymers & Services

Message:

Viprene™ P85A-22U-BLK is a UV and Heat Stabilized TPV (thermoplastic vulcanizate elastomer). This material can be easily procesed by extrusion or injection molding. It exhibits easy flowing characteristics.

| General Information |                    |
|---------------------|--------------------|
| Additive            | heat stabilizer    |
|                     | UV stabilizer      |
| Features            | Good UV resistance |
|                     | Good liquidity     |
|                     | Thermal Stability  |
| Appearance          | Black              |
| Forms               | Particle           |
| Processing Method   | Extrusion          |
|                     | Injection molding  |

| Physical                      | Nominal Value | Unit  | Test Method |
|-------------------------------|---------------|-------|-------------|
| Density                       | 0.960         | g/cm³ | ISO 2781    |
| Hardness                      | Nominal Value | Unit  | Test Method |
| Durometer Hardness (Shore A)  | 85            |       | ISO 868     |
| Elastomers                    | Nominal Value | Unit  | Test Method |
| Tensile Stress                |               |       | ISO 37      |
| 100% strain                   | 5.10          | MPa   | ISO 37      |
| 300% strain                   | 7.60          | MPa   | ISO 37      |
| Tensile Stress (Break)        | 11.8          | MPa   | ISO 37      |
| Tensile Elongation (Break)    | 550           | %     | ISO 37      |
| Tear Strength                 | 63            | kN/m  | ISO 34-1    |
| Compression Set (70°C, 22 hr) | 31            | %     | ASTM D395B  |
| Thermal                       | Nominal Value | Unit  | Test Method |
| Brittleness Temperature       | -60.0         | °C    | ASTM D746   |
| Flammability                  | Nominal Value |       | Test Method |
| Flame Rating                  |               |       | UL 94       |
| 1.00 mm                       | HB            |       | UL 94       |
| 1.50 mm                       | HB            |       | UL 94       |
| 3.00 mm                       | HB            |       | UL 94       |
| Injection                     | Nominal Value | Unit  |             |

|                        |               |                    |
|------------------------|---------------|--------------------|
| Drying Temperature     | 80.0          | °C                 |
| Drying Time            | 3.0           | hr                 |
| Rear Temperature       | 180           | °C                 |
| Middle Temperature     | 185           | °C                 |
| Front Temperature      | 190           | °C                 |
| Nozzle Temperature     | 195 - 225     | °C                 |
| Processing (Melt) Temp | 200 - 230     | °C                 |
| Mold Temperature       | 10.0 - 50.0   | °C                 |
| Back Pressure          | 0.400 - 0.800 | MPa                |
| Screw Speed            | 100 - 200     | rpm                |
| Clamp Tonnage          | 4.0 - 7.0     | kN/cm <sup>2</sup> |

#### Injection instructions

Injection Speed: 50 mm/sec or more

| Extrusion             | Nominal Value | Unit |
|-----------------------|---------------|------|
| Drying Temperature    | 80.0          | °C   |
| Drying Time           | 3.0           | hr   |
| Cylinder Zone 1 Temp. | 180           | °C   |
| Cylinder Zone 2 Temp. | 190           | °C   |
| Cylinder Zone 3 Temp. | 195           | °C   |
| Die Temperature       | 205           | °C   |

#### Extrusion instructions

Gate Temperature: 200°C (392°F) Die Pressure: 4.8 to 17 MPa (696 to 2465 psi)

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#### Recommended distributors for this material

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