

# Santoprene™ 251-80W232

## Thermoplastic Vulcanizate

### Product Description

A soft, colorable, flame retardant thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material has good fluid resistance and contains non-ether brominated flame retardants. It does not contain metal deactivators. 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

- UL listed: file #QMFZ2.E80017, Plastics - Component; file #QMFZ8.E80017, Plastics Certified For Canada - Component; file #QMTT2.E86313, Polymeric Materials for Use in Wire, Cable and Flexible Lighting Products - Component.
- Recommended for applications requiring a flame retardant material - UL 94 Vertical Flame rated.
- Recommended for applications requiring excellent flex fatigue resistance.
- Recommended for applications requiring excellent ozone resistance.

### General

Availability <sup>1</sup>	<ul style="list-style-type: none"> <li>Africa &amp; Middle East</li> <li>Asia Pacific</li> </ul>	<ul style="list-style-type: none"> <li>Europe</li> <li>Latin America</li> </ul>	<ul style="list-style-type: none"> <li>North America</li> </ul>
Applications	<ul style="list-style-type: none"> <li>Automotive - Flame Retardant Connectors and Seals</li> </ul>	<ul style="list-style-type: none"> <li>Electrical - Flame Retardant Connectors and Seals</li> </ul>	<ul style="list-style-type: none"> <li>Electrical - Flame Retardant Wire and Cable Jacket</li> </ul>
Uses	<ul style="list-style-type: none"> <li>Automotive Applications</li> <li>Cable Jacketing</li> </ul>	<ul style="list-style-type: none"> <li>Flexible Cord Jacketing</li> <li>Wire &amp; Cable Applications</li> </ul>	
Agency Ratings	<ul style="list-style-type: none"> <li>UL QMFZ2</li> </ul>	<ul style="list-style-type: none"> <li>UL QMFZ8</li> </ul>	<ul style="list-style-type: none"> <li>UL QMTT2</li> </ul>
RoHS Compliance	<ul style="list-style-type: none"> <li>RoHS Compliant</li> </ul>		
Automotive Specifications	<ul style="list-style-type: none"> <li>CHRYSLER MS-AR-100 AFN</li> </ul>		
UL File Number	<ul style="list-style-type: none"> <li>E86313</li> </ul>	<ul style="list-style-type: none"> <li>E80017</li> </ul>	
Color	<ul style="list-style-type: none"> <li>Natural Color</li> </ul>		
Form(s)	<ul style="list-style-type: none"> <li>Pellets</li> </ul>		
Processing Method	<ul style="list-style-type: none"> <li>Blow Molding</li> <li>Coextrusion</li> <li>Extrusion</li> <li>Extrusion Blow Molding</li> </ul>	<ul style="list-style-type: none"> <li>Injection Blow Molding</li> <li>Injection Molding</li> <li>Multi Injection Molding</li> <li>Profile Extrusion</li> </ul>	<ul style="list-style-type: none"> <li>Sheet Extrusion</li> <li>Thermoforming</li> <li>Vacuum Forming</li> </ul>
Revision Date	<ul style="list-style-type: none"> <li>06/20/2014</li> </ul>		

Physical	Typical Value (English)	Typical Value (SI)	Test Based On
Density / Specific Gravity	1.24	1.24	ASTM D792
Density	1.24 g/cm <sup>3</sup>	1.24 g/cm <sup>3</sup>	ISO 1183
Hardness	Typical Value (English)	Typical Value (SI)	Test Based On
Shore Hardness			ISO 868
Shore A, 15 sec, 73°F (23°C)	86	86	

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Elastomers	Typical Value (English)	Typical Value (SI)	Test Based On
Tensile Stress at 100% - Across Flow (73°F (23°C))	566 psi	3.90 MPa	ASTM D412
Tensile Stress at 100% - Across Flow (73°F (23°C))	566 psi	3.90 MPa	ISO 37
Tensile Strength at Break - Across Flow (73°F (23°C))	1310 psi	9.00 MPa	ASTM D412
Tensile Stress at Break - Across Flow (73°F (23°C))	1310 psi	9.00 MPa	ISO 37
Elongation at Break - Across Flow (73°F (23°C))	550 %	550 %	ASTM D412
Tensile Strain at Break - Across Flow (73°F (23°C))	550 %	550 %	ISO 37
Compression Set			ASTM D395B
73°F (23°C), 168 hr, Type 1	31 %	31 %	
158°F (70°C), 22 hr, Type 1	40 %	40 %	
212°F (100°C), 168 hr, Type 1	55 %	55 %	
Compression Set			ISO 815
73°F (23°C), 168 hr, Type A	31 %	31 %	
158°F (70°C), 22 hr, Type A	40 %	40 %	
212°F (100°C), 168 hr, Type A	55 %	55 %	
Thermal	Typical Value (English)	Typical Value (SI)	Test Based On
RTI Elec	194 °F	90.0 °C	UL 746
RTI Str			UL 746
0.06 in (1.5 mm)	185 °F	85.0 °C	
0.12 in (3.0 mm)	194 °F	90.0 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Based On
Dielectric Strength			ASTM D149
73°F (23°C), 0.0787 in (2.00 mm)	700 V/mil	28 kV/mm	
Comparative Tracking Index (CTI)	PLC 0	PLC 0	UL 746
High Amp Arc Ignition (HAI)	PLC 0	PLC 0	UL 746
High Voltage Arc Resistance to Ignition (HVAR)	PLC 6	PLC 6	UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 2	PLC 2	UL 746
Hot-wire Ignition (HWI)	PLC 3	PLC 3	UL 746
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 Re grind	20 %	20 %	
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 <sup>2</sup>	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	

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#### 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

#### Extrusion Notes

Santoprene™ TPV is incompatible with acetal and PVC. For more information regarding processing and die design, please consult our Extrusion Molding Guide.

Flammability	Typical Value (English)	Typical Value (SI)	Test Based On
Flame Rating			UL 94
0.06 in (1.5 mm)	V-0	V-0	
0.12 in (3.0 mm)	V-0	V-0	
Oxygen Index	27 %	27 %	ASTM D2863
Oxygen Index	27 %	27 %	ISO 4589-2

#### 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.

<sup>1</sup> 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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For additional technical, sales and order assistance: [www.exxonmobilchemical.com/ContactUs](http://www.exxonmobilchemical.com/ContactUs)

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