

SANTOPRENE® 8281-75MED

SANTOPRENE®

A soft, colorable, specialty, non-hygroscopic thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. It is designed for use in medical and healthcare applications. This grade of Santoprene™ TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding or blow molding. It is polyolefin based and recyclable within the manufacturing stream.

Key Features

- Biocompatibility in tests corresponding to USP Class VI/ISO 10993
- A representative grade undergoes annual testing for cytotoxicity and heavy metals
- Drug master file maintained with the FDA

Product information

Resin Identification	TPV	ISO 1043
Part Marking Code	>TPV<	ISO 11469

Typical mechanical properties

Shore A hardness, 15s	79	ISO 48-4 / ISO 868
Tensile stress at 100% elongation, perpendicular	522 psi	ISO 37
Tensile stress at break, perpendicular	1130 psi	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular	510 %	ISO 527-1/-2 or ISO 37
Compression set, 23°C	34 %	ISO 815
Time	168 h	
Compression set, 70°C, 24h	35 %	ISO 815
Compression set, 125°C, 24h	48 %	ISO 815

Physical/Other properties

Density	0.0332 lb/in ³	ISO 1183
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Injection

Drying Recommended	no
Drying Temperature	176 °F
Drying Time, Dehumidified Dryer	≥3 h
Processing Moisture Content	≤0.08 %
Max. regrind level	20 %
Melt Temperature Optimum	392 °F
Min. melt temperature	374 °F
Max. melt temperature	419 °F
Mold Temperature Optimum	95 °F
Min. mold temperature	68 °F
Max. mold temperature	122 °F

Characteristics

Processing	Injection Molding, Multi Injection Molding, Blow Molding, Injection Blow Molding, Extrusion Blow Molding, Extrusion - small Tubing
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Additional information

Injection molding

Holding pressure should be about 50 to 75% of the actual injection pressure.
A high screw RPM (100 to 200) is recommended.
Back pressure is not always needed, however, a back pressure of 0.3 to 0.7 MPa may be used to ensure a homogeneous melt and maintain a consistent shot size.
A higher back pressure is normally employed when using masterbatches.

Processing Notes

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If desired, desiccant drying for 3 hours at 80 °C (180 °F) can be performed.
Santoprene® TPV has a wide temperature processing window from 175 to 230 °C (350 to 450 °F) and is incompatible with acetal and PVC.

Santoprene® TPV has a relatively high melt viscosity at low shear rates. Viscosity decreases as the shear rate increases.
Increasing temperature has little effect on TPV melt viscosity. Smaller gates and higher shear rates keep melt viscosity low and improve melt flow. Please also refer to the injection molding guide.