Celanese
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SANTOPRENE® 251-70W232

SANTOPRENE®

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 or blow molding. 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.
- 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.

Product information

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

Rheological properties

Moulding shrinkage, parallel	1.3[1]	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.6[1]	%	ISO 294-4, 2577

[1]: 2.0 mm thickness, min. 24 hours after molding, per test method TPE-X0080

Typical mechanical properties

Tensile stress at 100% elongation, perpendicular	2.7	MPa	ISO 37
Tensile stress at break, perpendicular	6.3	MPa	ISO 527-1/-2 or ISO 37
Elongation at break, perpendicular	550	%	ISO 527-1/-2 or ISO 37
Shore A hardness, 15s	75		ISO 48-4 / ISO 868

Thermal properties

RTI, electrical, 1.5mm	90	°C	UL 746B
RTI, electrical, 3.0mm	90	°C	UL 746B
RTI, strength, 1.5mm	85	°C	UL 746B
RTI, strength, 3.0mm	90	°C	UL 746B

Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	1	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Oxygen index	26	%	ISO 4589-1/-2
Hot Wire Ignition, 1.5mm	PLC 3	s	UL 746A

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Electrical properties

Relative permittivity, 60Hz	2.5		IEC 62631-2-1
Comparative tracking index, 23 °C	0	PLC	UL 746A
Arc Resistance Performance Level Category	PLC 6	class	UL 746B
High Amperage Arc Ignition Category, 1.5 mm	PLC 0	class	UL 746A

Physical/Other properties

Density	1270	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	≥3	h
Processing Moisture Content	≤0.08	%
Max. regrind level	20	%
Melt Temperature Optimum	200	°C
Min. melt temperature	190	°C
Max. melt temperature	210	°C
Mold Temperature Optimum	30	°C
Min. mould temperature	10	°C
Max. mould temperature	50	°C

Extrusion

Drying Temperature	82	°C
Drying Time, Dehumidified Dryer	3	h

Characteristics

Processing	Injection Moulding, Multi Injection Moulding, Extrusion, Sheet Extrusion, Blow Moulding
Delivery form	Pellets
Special characteristics	Flame retardant

Additional information

Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength	150 °C, 168h	-21	%	ISO 188
Change in Tensile Strain at Break	150 °C, 168h	-25	%	ISO 188

Injection molding	Holding pressure should be about 50 to 75% of the actual injection pressure.

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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

Processing Notes

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.

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.

Automotive

OEM	ADDITIONAL INFORMATION
General Motors	Special Parts Approval, See Your CE Account Representative for Further Details.

Revised: 2025-04-21 Source: Celanese Materials Database