Celanese
The chemistry inside innovation™

SANTOPRENE® 291-75B150

SANTOPRENE®

Santoprene® 291-75B150 is a colorable, specialty thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. It is especially formulated to bond to PC, ABS, PC/ABS, ASA and PMMA for applications where hard/soft combinations are required. This grade of Santoprene® TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding or extrusion.

Key Features

- Designed for excellent adhesion to PC, ABS, PC/ABS, ASA and PMMA (cold insert or 2K [two-shot] molding).
- Broad processing window in injection molding.
- Recommended for applications requiring superior part surface appearance.
- Designed for soft touch applications.
- UL listed: file #QMFZ2.E80017, Plastics - Component; file #QMFZ8.E80017, Plastics Certified For Canada - Component.

Product information

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

Typical mechanical properties

Shore A hardness, 15s	78		ISO 48-4 / ISO 868
Compression set, 23 °C, 24h	38	%	ISO 815
Compression set, 70 °C, 24h	68	%	ISO 815

Physical/Other properties

Density	1090	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	≥3	h
Processing Moisture Content	≤0.03	%
Melt Temperature Optimum	210	°C
Min. melt temperature	190	°C
Max. melt temperature	230	°C
Mold Temperature Optimum	40	°C
Min. mould temperature	30	°C
Max. mould temperature	50	°C

Characteristics

Processing	Injection Moulding, Multi Injection Moulding, Coextrusion
Delivery form	Pellets

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.

Celanese
The chemistry inside innovation™

SANTOPRENE® 291-75B150

SANTOPRENE®

	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.
VW Group	VW 50123

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