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**Product Data Sheet &  
General Processing Conditions**

**Permaprene® 2800 B-45A HF  
Thermoplastic Vulcanizate (TPV)  
High Flow**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| <b>PERMANENCE</b>                                                                                    | <b>English</b>        | <b>SI Metric</b>     | <b>ASTM<br/>TEST</b> |
|------------------------------------------------------------------------------------------------------|-----------------------|----------------------|----------------------|
| Specific Gravity                                                                                     | 1.02                  | 1.02                 | D 792                |
| <b>MECHANICAL</b>                                                                                    |                       |                      |                      |
| Tensile Strength<br>Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)                                   | 480 psi               | 3 MPa                | D 412                |
| Tensile Elongation<br>Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)                          | 450.0 %               | 450.0 %              | D 412                |
| Tensile Stress<br>Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min)<br>@ 100 %                          | 180.0 psi<br>75.0 pli | 1.2 MPa<br>13.1 N/mm | D 412<br>D 624       |
| Tear Strength, Die C                                                                                 |                       |                      |                      |
| Compression Set<br>22 h @ 23 °C (73 °F), Method B, Type 2<br>22 h @ 70 °C (158 °F), Method B, Type 2 | 16 %<br>29 %          | 16 %<br>29 %         | D 395<br>D 395       |
| Hardness<br>Shore A, 10 s delay                                                                      | 45                    | 45                   | D 2240               |

**PROPERTY NOTES**

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

**GENERAL PROCESSING FOR INJECTION MOLDING**

|                  | <b>English</b> | <b>SI Metric</b> |
|------------------|----------------|------------------|
| Melt Temperature | 360 - 410 °F   | 182 - 210 °C     |
| Mold Temperature | 60 - 150 °F    | 16 - 66 °C       |
| Drying           | 2 hrs @ 175 °F | 2 hrs @ 79 °C    |
| Moisture Content | < 0.03 %       | < 0.03 %         |
| Dew Point        | 0 °F           | -18 °C           |