

## SANTOPRENE™ 271-55 - TPV

### Product Description

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

### Characteristics

<b>Applications</b>	Consumer - FDA Seals and Closures, Consumer - Packaging, Consumer - Small Appliance, Consumer - Soft Touch Grips, Seals and Gaskets
<b>Uses</b>	Filters, Flexible grips, Food containers, Gaskets, Kitchenware, Living hinges, Non-specific food applications, Seals, Tubing, White goods & small appliances
<b>Agency Ratings</b>	NSF 51, UL QMFZ2, UL QMFZ8
<b>UL File Number</b>	E80017
<b>Color</b>	Natural color
<b>Delivery Form</b>	Pellets
<b>Processing</b>	Coextrusion, Extrusion, Injection molding, Multi injection molding, Profile extrusion, Sheet extrusion

Physical properties	Value	Unit	Test Standard
Density	0.97	g/cm <sup>3</sup>	ASTM D792
Density	970	kg/m <sup>3</sup>	ISO 1183
Hardness	Value	Unit	Test Standard
Shore A hardness-TPE, 15s	59		ISO 868
Mechanical properties	Value	Unit	Test Standard
Tensile stress at 100%, perpendicular	1.9	MPa	ASTM D412
Tensile stress at 100%, perpendicular	1.9	MPa	ISO 37
Tensile strength at break elast, perpendicular	4.5	MPa	ASTM D412
Tensile stress at break, perpendicular	4.5	MPa	ISO 37
Elongation at break elast, perpendicular	390	%	ASTM D412
Tensile strain at break, perpendicular	390	%	ISO 37
Compression set, 70 °C, 22h, Type 1, Method B	22	%	ASTM D395
Compression set, 70 °C, 22h, Type A	22	%	ISO 815
Compression set, 125 °C, 70h, Type 1, Method B	38	%	ASTM D395
Compression set, 125 °C, 70h, Type A	38	%	ISO 815
Thermal properties	Value	Unit	Test Standard
Brittleness temperature	-60	°C	ASTM D746
Injection	Value	Unit	Test Standard
Drying temperature	82	°C	
Drying time	3	h	
Necessary low maximum residual moisture content	0.08	%	
Suggested maximum regrind	20	%	
Rear temperature	177	°C	
Middle temperature	182	°C	
Front temperature	182	°C	
Nozzle temperature	188 - 221	°C	
Melt temperature	193 - 232	°C	
Mold temperature	10 - 52	°C	

## SANTOPRENE™ 271-55 - TPV

Injection speed	<b>fast</b>	-
Back pressure	<b>0.345 - 0.689</b>	MPa
Screw Speed	<b>100 - 200</b>	RPM
Clamp tonnage	<b>41 - 69</b>	MPa
Cushion	<b>3.18 - 6.35</b>	mm
Screw L/D	<b>20:1/*</b>	-
Screw compression ratio	<b>2.5:1/*</b>	-
Vent depth	<b>0.025</b>	mm

<b>Extrusion</b>	<b>Value</b>	<b>Unit</b>
Drying temperature	<b>82</b>	°C
Drying time	<b>3</b>	h
Melt temperature	<b>196</b>	°C
Die head temperature	<b>199</b>	°C
Back pressure	<b>5 - 20</b>	MPa

<b>Aging</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Change in Tensile Strength in Air @ 150 C, 168 h	<b>-7</b>	%	ASTM D573
Change in Tensile Strength in Air @ 150 C, 168 h	<b>-7</b>	%	ISO 188
Change in Ultimate Elongation in Air @ 150 C, 168 h	<b>13</b>	%	ASTM D573
Change in Tensile Strain at Break in Air @ 150 C, 168 h	<b>13</b>	%	ISO 188
Change in Durometer Hardness in Air @ 150 C, 168 h, Shore A	<b>3</b>	-	ASTM D573
Change in Shore Hardness in Air @ 150 C, 168 h, Shore A	<b>3</b>	-	ISO 188

### Other text information

### 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.

### Contact

#### Americas

8040 Dixie Highway  
Florence, KY 41042 USA  
Product Information Service  
t: +1-800-833-4882  
t: +1-859-372-3244  
Customer Service  
t: +1-800-526-4960  
t: +1-859-372-3214  
e: info-engineeredmaterials-am@celanese.com

#### Asia

4560 Jinke Road  
Zhang Jiang Hi Tech Park  
Shanghai 201210 PRC  
Customer Service  
t: +86 21 3861 9288  
e: info-engineeredmaterials-asia@celanese.com

#### Europe

Am Unisys-Park 1  
65843 Sulzbach, Germany  
Product Information Service  
t: +49-800-86427-531  
t: +49-(0)-69-45009-1011  
e: info-engineeredmaterials-eu@celanese.com

### General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products. The products mentioned herein are not intended for use in medical or dental implants.

---

## SANTOPRENE™ 271-55 - TPV

---

### Trademark

---

© 2021 Celanese or its affiliates. All rights reserved. Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC.