

Santoprene™ 121-87

Thermoplastic Vulcanizate

Product Description

A hard, black, UV resistant thermoplastic vulcanizate (TPV) in the thermoplastic elastomer (TPE) family. This material combines good physical properties and chemical resistance for use in a wide range of applications. This grade of Santoprene TPV is shear-dependent and can be processed on conventional thermoplastics equipment for injection molding, extrusion, blow molding, thermoforming or vacuum forming. It is polyolefin based and recyclable within the manufacturing stream.

Key Features

- Recommended for applications requiring excellent flex fatigue resistance.
- Excellent ozone resistance.
- Designed for improved UV resistance.

General

Applications	▪ Automotive - Interior Mat	▪ Automotive - Seals and Gaskets	▪ Automotive - Weather Seals
Uses	▪ Automotive Applications	▪ Automotive Interior Trim	
	▪ Automotive Exterior Trim	▪ Outdoor Applications	
RoHS Compliance	▪ RoHS Compliant		
Automotive Specifications	▪ CHRYSLER MS-AR-100 EGV	▪ FORD WSS-M2D382-B1	▪ GM GMW15812, Type 8E
Color	▪ Black		
Form(s)	▪ Pellets		
Processing Method	▪ Blow Molding	▪ Injection Blow Molding	▪ Sheet Extrusion
	▪ Coextrusion	▪ Injection Molding	▪ Thermoforming
	▪ Extrusion	▪ Multi Injection Molding	▪ Vacuum Forming
	▪ Extrusion Blow Molding	▪ Profile Extrusion	

Physical	Typical Value (English)	Typical Value (SI)	Test Based On
Density / Specific Gravity	0.970	0.970	ASTM D792
Density	0.970 g/cm ³	0.970 g/cm ³	ISO 1183

Hardness	Typical Value (English)	Typical Value (SI)	Test Based On
Shore Hardness			ISO 868
Shore A, 15 sec, 73°F (23°C)	93	93	

Elastomers	Typical Value (English)	Typical Value (SI)	Test Based On
Tensile Stress at 100% - Across Flow (73°F (23°C))	986 psi	6.80 MPa	ASTM D412
Tensile Stress at 100% - Across Flow (73°F (23°C))	986 psi	6.80 MPa	ISO 37
Tensile Strength at Break - Across Flow (73°F (23°C))	2200 psi	15.2 MPa	ASTM D412
Tensile Stress at Break - Across Flow (73°F (23°C))	2200 psi	15.2 MPa	ISO 37
Elongation at Break - Across Flow (73°F (23°C))	600 %	600 %	ASTM D412
Tensile Strain at Break - Across Flow (73°F (23°C))	600 %	600 %	ISO 37
Compression Set			ASTM D395B
73°F (23°C), 22 hr, Type 1	28 %	28 %	
257°F (125°C), 70 hr, Type 1	65 %	65 %	
Compression Set			ISO 815
73°F (23°C), 22 hr, Type A	28 %	28 %	
257°F (125°C), 70 hr, Type A	65 %	65 %	



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Thermal	Typical Value (English)	Typical Value (SI)	Test Based On
Brittleness Temperature	-72 °F	-58 °C	ASTM D746
Brittleness Temperature	-72 °F	-58 °C	ISO 812

Electrical	Typical Value (English)	Typical Value (SI)	Test Based On
Dielectric Strength 73°F (23°C), 0.0787 in (2.00 mm)	670 V/mil	26 kV/mm	ASTM D149
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.70	2.70	ASTM D150
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.70	2.70	IEC 60250

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	3.0 hr	3.0 hr
Suggested Max Moisture	0.080 %	0.080 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	360 °F	182 °C
Middle Temperature	370 °F	188 °C
Front Temperature	380 °F	193 °C
Nozzle Temperature	390 to 455 °F	199 to 235 °C
Processing (Melt) Temp	400 to 450 °F	204 to 232 °C
Mold Temperature	50 to 125 °F	10 to 52 °C
Injection Rate	Fast	Fast
Back Pressure	50.0 to 100 psi	0.345 to 0.689 MPa
Screw Speed	100 to 200 rpm	100 to 200 rpm
Clamp Tonnage	3.0 to 5.0 tons/in ²	41 to 69 MPa
Cushion	0.125 to 0.250 in	3.18 to 6.35 mm
Screw L/D Ratio	16.0:1.0 to 20.0:1.0	16.0:1.0 to 20.0:1.0
Screw Compression Ratio	2.0:1.0 to 2.5:1.0	2.0:1.0 to 2.5:1.0
Vent Depth	1.0E-3 in	0.025 mm

Injection Notes

Santoprene™ TPV is incompatible with acetal and PVC. For more information regarding processing and mold design, please consult our Injection Molding Guide.

Extrusion	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	3.0 hr	3.0 hr
Melt Temperature	400 °F	204 °C
Die Temperature	410 °F	210 °C
Back Pressure	725 to 2900 psi	5.00 to 20.0 MPa



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Aging	Typical Value (English)	Typical Value (SI)	Test Based On
Change in Tensile Strength in Air 275°F (135°C), 1008 hr	-3.0 %	-3.0 %	ASTM D573
Change in Tensile Strength in Air 275°F (135°C), 1008 hr	-3.0 %	-3.0 %	ISO 188
Change in Ultimate Elongation in Air 275°F (135°C), 1008 hr	-14 %	-14 %	ASTM D573
Change in Tensile Strain at Break in Air 275°F (135°C), 1008 hr	-14 %	-14 %	ISO 188
Change in Durometer Hardness in Air Shore A, 275°F (135°C), 1008 hr	1.0	1.0	ASTM D573
Change in Shore Hardness in Air Shore A, 275°F (135°C), 1008 hr	1.0	1.0	ISO 188
Continuous Upper Temperature Resistance 1008 hr	275 °F	135 °C	SAE J2236

