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**Product Data Sheet &  
General Processing Conditions**

**Permaprene™ 2840 B-75A  
Thermoplastic Elastomer Alloy  
TPV Alloy**

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

| <b>PERMANENCE</b>                                                           | <b>English</b>         | <b>SI Metric</b>     | <b>ASTM<br/>TEST</b> |
|-----------------------------------------------------------------------------|------------------------|----------------------|----------------------|
| Specific Gravity                                                            | 1.12                   | 1.12                 | D 792                |
| <b>MECHANICAL</b>                                                           |                        |                      |                      |
| Tensile Strength<br>Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)          | 950 psi                | 7 MPa                | D 412                |
| Tensile Elongation<br>Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min) | 800.0 %                | 800.0 %              | D 412                |
| Tensile Stress<br>Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min)<br>@ 100 % | 350.0 psi<br>210.0 pli | 2.4 MPa<br>36.8 N/mm | D 412<br>D 624       |
| Tear Strength, Die C                                                        |                        |                      |                      |
| Compression Set<br>22 h @ 23 °C (73 °F), Method B, Type 2                   | 40 %                   | 40 %                 | D 395                |
| 22 h @ 70 °C (158 °F), Method B, Type 2                                     | 70 %                   | 70 %                 | D 395                |
| Hardness<br>Shore A, 10 s delay                                             | 75                     | 75                   | 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 - 120 °F    | 16 - 49 °C       |
| Drying           | 2 hrs @ 175 °F | 2 hrs @ 79 °C    |
| Moisture Content | < 0.05 %       | < 0.05 %         |