



**Product Data Sheet &
General Processing Conditions**

**Permaprene® 2800 B-65A
Thermoplastic Vulcanizate (TPV)**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|---|-----------------------|------------------|------------------|
| Specific Gravity | 1.02 | 1.02 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0120 - 0.0180 in/in | 1.20 - 1.80 % | D 955 |
| MECHANICAL | | | |
| Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min) | 800 psi | 6 MPa | D 412 |
| Tensile Elongation Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min) | 500.0 % | 500.0 % | D 412 |
| Tensile Stress Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min) @ 100 % | 350.0 psi | 2.4 MPa | D 412 |
| Tear Strength, Die C | 145.0 pli | 25.4 N/mm | D 624 |
| Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2 | 22 % | 22 % | D 395 |
| 22 h @ 70 °C (158 °F), Method B, Type 2 | 36 % | 36 % | D 395 |
| Hardness Shore A, 10 s delay | 68 | 68 | 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

| | English | SI Metric |
|------------------|----------------|------------------|
| 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 | < 0.05 % | < 0.05 % |
| Dew Point | 0 °F | -18 °C |

PROCESSING NOTES

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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