



**Product Data Sheet &
General Processing Conditions**

**Permaprene® 2800 B-85A
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	0.0130 - 0.0190 in/in	1.30 - 1.90 %	D 955
MECHANICAL			
Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	1500 psi	10 MPa	D 412
Tensile Elongation Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	750.0 %	750.0 %	D 412
Tensile Stress Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min) @ 100 %	880.0 psi	6.1 MPa	D 412
Tear Strength, Die C	280.0 pli	49.1 N/mm	D 624
Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2	35 %	35 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	56 %	56 %	D 395
Hardness Shore A, 10 s delay	85	85	D 2240
THERMAL			
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

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.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Melt Temperature	380 - 440 °F	193 - 227 °C
Mold Temperature	70 - 175 °F	21 - 79 °C
Drying	2 - 3 hrs @ 175 °F	2 - 3 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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