

Santoprene™ 203-50

Thermoplastic Vulcanizate

Product Description

A hard, colorable, versatile 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

- UL listed: file #QMFZ2.E80017, Plastics - Component; file #QMFZ8.E80017, Plastics Certified For Canada - Component.
- Excellent ozone resistance.

General

Applications	General Purpose		
Uses	- Appliance Components - Automotive Applications - Automotive Under the Hood	- Consumer Applications - Diaphragms - Electrical Parts	- Living Hinges - Tubing
Agency Ratings	UL QMFZ2	UL QMFZ8	
RoHS Compliance	RoHS Compliant		
Automotive Specifications	CHRYSLER MS-AR-100 GGN		
UL File Number	E80017		
Color	Natural Color		
Form(s)	Pellets		
Processing Method	- Blow Molding - Coextrusion - Extrusion - Extrusion Blow Molding	- Injection Blow Molding - Injection Molding - Multi Injection Molding - Profile Extrusion	- Sheet Extrusion - Thermoforming - Vacuum Forming

Physical	Typical Value (English)	Typical Value (SI)	Test Based On
Density / Specific Gravity	0.950	0.950	ASTM D792
Density	0.950 g/cm ³	0.950 g/cm ³	ISO 1183
Detergent Resistance	f3	f3	UL 749
Detergent Resistance	f4	f4	UL 2157

Hardness	Typical Value (English)	Typical Value (SI)	Test Based On
Shore Hardness			ISO 868
Shore D, 15 sec, 73°F (23°C)	51	51	

Mechanical	Typical Value (English)	Typical Value (SI)	Test Based On
Tensile Strength at Yield - Across Flow (73°F (23°C))	1740 psi	12.0 MPa	ASTM D638
Tensile Stress at Yield - Across Flow (73°F (23°C))	1740 psi	12.0 MPa	ISO 527-2
Elongation at Yield - Across Flow (73°F (23°C))	31 %	31 %	ASTM D638
Tensile Strain at Yield - Across Flow (73°F (23°C))	31 %	31 %	ISO 527-2



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Elastomers	Typical Value (English)	Typical Value (SI)	Test Based On
Tear Strength - Across Flow 73°F (23°C), Method Ba, Angle (Unnicked)	550 lbf/in	96 kN/m	ISO 34-1
Compression Set 158°F (70°C), 22 hr, Type 1 257°F (125°C), 70 hr, Type 1	59 % 74 %	59 % 74 %	ASTM D395B
Compression Set 158°F (70°C), 22 hr, Type A 257°F (125°C), 70 hr, Type A	59 % 74 %	59 % 74 %	ISO 815
Thermal	Typical Value (English)	Typical Value (SI)	Test Based On
Brittleness Temperature	-18 °F	-28 °C	ASTM D746
Brittleness Temperature	-18 °F	-28 °C	ISO 812
RTI Elec	185 °F	85.0 °C	UL 746
RTI Str	185 °F	85.0 °C	UL 746
Electrical	Typical Value (English)	Typical Value (SI)	Test Based On
Dielectric Strength 73°F (23°C), 0.0787 in (2.00 mm)	890 V/mil	35 kV/mm	ASTM D149
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.30	2.30	ASTM D150
Dielectric Constant 73°F (23°C), 0.0780 in (1.98 mm)	2.30	2.30	IEC 60250
Comparative Tracking Index (CTI)	PLC 0	PLC 0	UL 746
High Amp Arc Ignition (HAI)	PLC 0	PLC 0	UL 746
High Voltage Arc Resistance to Ignition (HVAR)	PLC 5	PLC 5	UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 1	PLC 1	UL 746
Hot-wire Ignition (HWI) 0.04 in (1.0 mm) 0.06 in (1.5 mm) 0.12 in (3.0 mm)	PLC 3 PLC 3 PLC 1	PLC 3 PLC 3 PLC 1	UL 746
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	380 °F	193 °C	
Middle Temperature	390 °F	199 °C	
Front Temperature	400 °F	204 °C	
Nozzle Temperature	410 to 465 °F	210 to 241 °C	
Processing (Melt) Temp	420 to 450 °F	216 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	



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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	410 °F	210 °C
Die Temperature	420 °F	216 °C
Back Pressure	725 to 2900 psi	5.00 to 20.0 MPa

Extrusion Notes

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Aging	Typical Value (English)	Typical Value (SI)	Test Based On
Change in Tensile Strength in Air 302°F (150°C), 168 hr	-32 %	-32 %	ASTM D573
Change in Tensile Strength in Air 302°F (150°C), 168 hr	-32 %	-32 %	ISO 188
Change in Ultimate Elongation in Air 302°F (150°C), 168 hr	-27 %	-27 %	ASTM D573
Change in Tensile Strain at Break in Air 302°F (150°C), 168 hr	-27 %	-27 %	ISO 188
Change in Durometer Hardness in Air Shore D, 302°F (150°C), 168 hr	5.0	5.0	ASTM D573
Change in Shore Hardness in Air Shore D, 302°F (150°C), 168 hr	5.0	5.0	ISO 188

Flammability	Typical Value (English)	Typical Value (SI)	Test Based On
Flame Rating			UL 94
0.04 in (1.0 mm)	HB	HB	
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

