

# SANTOPRENE® 203-50

## SANTOPRENE®

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.

### Product information

Resin Identification	TPV	ISO 1043
Part Marking Code	>TPV<	ISO 11469

### Typical mechanical properties

Yield stress, perpendicular	12 MPa	ISO 527-1/-2 or ISO 37
Yield strain, perpendicular	31 %	ISO 527-1/-2 or ISO 37
Brittleness Temperature	-28 °C	ASTM D 746
Low temperature brittleness	-28 °C	ISO 812
Shore D hardness, 15s	51	ISO 48-4 / ISO 868
Compression set, 70 °C, 24h	59 %	ISO 815
Compression set, 125 °C, 70h	74 %	ISO 815
Tear strength, normal	96 kN/m	ISO 34-1

### Thermal properties

RTI, electrical, 1.5mm	85 °C	UL 746B
RTI, electrical, 3.0mm	85 °C	UL 746B
RTI, strength, 1.5mm	85 °C	UL 746B
RTI, strength, 3.0mm	85 °C	UL 746B

### Specific Application Suitability

Detergent resistance	f3	UL 749
Detergent resistance	f4	UL 2157

### Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	IEC 60695-11-10
Thickness tested	1.5 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	1 mm	IEC 60695-11-10
UL recognition	yes	UL 94
Hot Wire Ignition, 1.5mm	PLC 3 s	UL 746A
Hot Wire Ignition, 3mm	PLC 1 s	UL 746A

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### Electrical properties

Relative permittivity, 60Hz	2.3	IEC 62631-2-1
Comparative tracking index, 23 °C	0 PLC	UL 746A
Arc Resistance Performance Level Category	PLC 5 class	UL 746B
High Amperage Arc Ignition Category, 1.5 mm	PLC 0 class	UL 746A

### Physical/Other properties

Density	950 kg/m <sup>3</sup>	ISO 1183
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### Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	≥3 h
Processing Moisture Content	≤0.08 %
Max. regrind level	20 %
Melt Temperature Optimum	220 °C
Min. melt temperature	205 °C
Max. melt temperature	230 °C
Mold Temperature Optimum	30 °C
Min. mould temperature	10 °C
Max. mould temperature	50 °C

### Extrusion

Drying Temperature	82 °C
Drying Time, Dehumidified Dryer	3 h
Melt Temperature Range	210 °C

### Characteristics

Processing	Injection Moulding, Multi Injection Moulding, Extrusion, Sheet Extrusion, Coextrusion, Blow Moulding, Thermoforming
Delivery form	Pellets

### Additional information

#### Non Standard Data

Property Name	Condition	Value	Unit	Standard
Change in Tensile Strength at Break	150 °C, 168h	-18	%	ISO 188
Change in Tensile Strain at Break	150 °C, 168h	-26	%	ISO 188
Change in Shore D	150 °C, 168h	-1	-	ISO 188

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Hardness				
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## Injection molding

Holding pressure should be about 50 to 75% of the actual injection pressure.  
A high screw RPM (100 to 200) is recommended.  
Back pressure is not always needed, however, a back pressure of 0.3 to 0.7 MPa may be used to ensure a homogeneous melt and maintain a consistent shot size.  
A higher back pressure is normally employed when using masterbatches.

## Processing Notes

### Processing Notes

Desiccant drying for 3 hours at 80°C (180°F) is recommended. Santoprene® TPV has a wide temperature processing window from 175 to 230°C (350 to 450°F) and is incompatible with acetal and PVC.

Santoprene® TPV has a relatively high melt viscosity at low shear rates. Viscosity decreases as the shear rate increases.

Increasing temperature has little effect on TPV melt viscosity. Smaller gates and higher shear rates keep melt viscosity low and improve melt flow. Please also refer to the injection molding guide.

## Automotive

OEM  
VW Group

STANDARD  
VW 50123