

# Arnitel<sup>®</sup> EL630-08

## TPC-ET

Food Contact Quality, Injection Molding

Print Date: 2024-03-27

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	VALUE		
Melt volume-flow rate	23	cm <sup>3</sup> /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage [parallel]	1.75	%	Sim. to ISO 294-4
Molding shrinkage [normal]	2	%	Sim. to ISO 294-4

<b>MECHANICAL PROPERTIES</b>			
	VALUE		
Shore D Hardness (3s)	58	—	ISO 868
Tensile modulus	310	MPa	ISO 527-1/-2
Stress at break	35	MPa	ISO 527-1/-2
Nominal strain at break	430	%	ISO 527-1/-2
Stress at 5% strain	12	MPa	ISO 527-1/-2
Stress at 10% strain	17	MPa	ISO 527-1/-2
Stress at 50% strain	18	MPa	ISO 527-1/-2
Stress at 100% strain	18	MPa	ISO 527-1/-2
Charpy notched impact strength (+23°C)	N	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength (-30°C)	12	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	N	kJ/m <sup>2</sup>	ISO 180/1A
Flexural modulus	340	MPa	ISO 178
Compression Set under constant strain at 70 °C	43	%	ISO 815

### MECHANICAL PROPERTIES (DIE CUTTING) VALUE

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Stress at break (normal)	45	MPa	ISO 527-1/-2
Tear strength (normal)	162	kN/m	ISO 34-1; Method B
Tear strength (parallel)	160	kN/m	ISO 34-1; Method B
Strain at break (normal)	740	%	ISO 527-1/-2
<b><i>THERMAL PROPERTIES</i></b>		<b><i>VALUE</i></b>	
Melting temperature (10°C/min)	210	°C	ISO 11357-1/-3
Temp. of deflection under load (0.45 MPa)	115	°C	ISO 75-1/-2
Vicat softening temperature (50°C/h 50N)	125	°C	ISO 306
Coeff. of linear therm. expansion (parallel)	1.85	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.85	E-4/°C	ISO 11359-1/-2
<b><i>ELECTRICAL PROPERTIES</i></b>		<b><i>VALUE</i></b>	
Relative permittivity (100Hz)	3.8	–	IEC 62631-2-1
Relative permittivity (1 MHz)	3.4	–	IEC 62631-2-1
Dissipation factor (100 Hz)	110	E-4	IEC 62631-2-1
Dissipation factor (1 MHz)	340	E-4	IEC 62631-2-1
Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
Electric strength	22	kV/mm	IEC 60243-1
Comparative tracking index	600	V	IEC 60112
<b><i>OTHER PROPERTIES</i></b>		<b><i>VALUE</i></b>	
Density	1240	kg/m <sup>3</sup>	ISO 1183
Apparent density	770	kg/m <sup>3</sup>	ISO 60
Water absorption	0.6	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62

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