

Arnitel® CM622

TPC-ES

60 Shore D, Extrusion

Properties	Typical Data	Unit	Test Method
Rheological properties			
	Value		
Melt volume-flow rate	9	cm ³ /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Mechanical properties			
	Value		
Shore D Hardness (3s)	61	-	ISO 868
Shore D Hardness (15s)	61	-	ISO 868
Shore A Hardness (3s)	98	-	ISO 868
Shore A Hardness (15s)	98	-	ISO 868
Tensile modulus	300	MPa	ISO 527-1/-2
Stress at break	34	MPa	ISO 527-1/-2
Nominal strain at break	400	%	ISO 527-1/-2
Stress at 5% strain	14	MPa	ISO 527-1/-2
Stress at 10% strain	19	MPa	ISO 527-1/-2
Stress at 50% strain	22	MPa	ISO 527-1/-2
Stress at 100% strain	21	MPa	ISO 527-1/-2
Charpy notched impact strength (+23°C)	N	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (-30°C)	8	kJ/m ²	ISO 179/1eA
Izod notched impact strength (-30°C)	6	kJ/m ²	ISO 180/1A
Flexural modulus	270	MPa	ISO 178
Compression Set under constant strain at 70 °C	37	%	ISO 815

Mechanical properties (die cutting)

Value



Property Data

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Stress at break (normal)	40	MPa	ISO 527-1/-2
Tear strength (normal)	171	kN/m	ISO 34-1; Method B
Tear strength (parallel)	191	kN/m	ISO 34-1; Method B
Strain at break (normal)	640	%	ISO 527-1/-2

Thermal properties

Value

Melting temperature (10°C/min)	208	°C	ISO 11357-1/-3
Vicat softening temperature (50°C/h 50N)	90	°C	ISO 306
Vicat softening temperature (50°C/h 10N)	190	°C	ISO 306

Other properties

Value

Density	1270	kg/m ³	ISO 1183
Humidity absorption	0.1	%	Sim. to ISO 62

