

Arnitel® EL630

TPC-ET

Injection Molding, Food Contact Quality

Properties	Typical Data	Unit	Test Method
Rheological properties			
	Value		
Melt volume-flow rate	28	cm ³ /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
Mechanical properties			
	Value		
Shore D Hardness (3s)	59	-	ISO 868
Tensile modulus	300	MPa	ISO 527-1/-2
Stress at break	35	MPa	ISO 527-1/-2
Nominal strain at break	490	%	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 ²	ISO 179/1eA
Charpy notched impact strength (-30°C)	12	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	N	kJ/m ²	ISO 180/1A
Flexural modulus	330	MPa	ISO 178
Compression Set under constant strain at 70 °C	43	%	ISO 815
Mechanical properties (die cutting)			
	Value		
Stress at break (normal)	43	MPa	ISO 527-1/-2



Properties	Typical Data	Unit	Test Method
Tear strength (normal)	163	kN/m	ISO 34-1; Method B
Tear strength (parallel)	161	kN/m	ISO 34-1; Method B
Strain at break (normal)	740	%	ISO 527-1/-2

Thermal properties

Value

Melting temperature (10°C/min)	212	°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
Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10

Electrical properties

Value

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

Other properties

Value

Density	1240	kg/m ³	ISO 1183
Apparent density	770	kg/m ³	ISO 60
Water absorption	0.6	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62

