

Arnitel® PM471

TPC-ET

Injection Molding

Properties	Typical Data	Unit	Test Method
Rheological properties			
	Value		
Melt volume-flow rate	12.5	cm ³ /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage [parallel]	1.6	%	Sim. to ISO 294-4
Molding shrinkage [normal]	1.6	%	Sim. to ISO 294-4
Mechanical properties			
	Value		
Shore D Hardness (3s)	44	-	ISO 868
Tensile modulus	170	MPa	ISO 527-1/-2
Stress at break	15	MPa	ISO 527-1/-2
Nominal strain at break	165	%	ISO 527-1/-2
Stress at 5% strain	6.4	MPa	ISO 527-1/-2
Stress at 10% strain	8.8	MPa	ISO 527-1/-2
Stress at 50% strain	11	MPa	ISO 527-1/-2
Stress at 100% strain	12	MPa	ISO 527-1/-2
Charpy notched impact strength (+23°C)	N	kJ/m ²	ISO 179/1eA
Charpy notched impact strength (-30°C)	N	kJ/m ²	ISO 179/1eA
Izod notched impact strength (+23°C)	N	kJ/m ²	ISO 180/1A
Izod notched impact strength (-30°C)	N	kJ/m ²	ISO 180/1A
Flexural modulus	160	MPa	ISO 178
Mechanical properties (die cutting)			
	Value		
Stress at break (normal)	16	MPa	ISO 527-1/-2



Property Data

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Properties	Typical Data	Unit	Test Method
Tear strength (normal)	75	kN/m	ISO 34-1; Method B
Tear strength (parallel)	74	kN/m	ISO 34-1; Method B
Strain at break (normal)	320	%	ISO 527-1/-2
Thermal properties	Value		
Melting temperature (10°C/min)	217	°C	ISO 11357-1/-3
Other properties	Value		
Density	1200	kg/m ³	ISO 1183

