

TECHNICAL DATA SHEET

# Arnitel® CM622

Envalior  
TPC

**Processing**

Injection molding, Profile extrusion, Other extrusion

**Delivery Form**

Pellets

**Special Characteristics**

Heat stabilized or stable to heat

## Product Text

**Product Information**

60 Shore D, Extrusion

ISO 18064 TPC-ES

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	9	cm <sup>3</sup> /10min	ISO 1133
Temperature	230	°C	
Load	2.16	kg	
Mechanical Properties	Value	Unit	Standard
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m <sup>2</sup>	ISO 179/1eA
Shore D hardness	61		ISO 7619-1
Stress at 10% elongation	19	MPa	ISO 527
Stress at 100% elongation	21	MPa	
Strain at break TPE	>300	%	ISO 527
Stress at break TPE	34	MPa	ISO 527
Compression set at 70 °C, 24h	37	%	ISO 815
Thermal Properties	Value	Unit	Standard
Melting temperature, 10°C/min	208	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	-10	°C	ISO 11357-1/-2

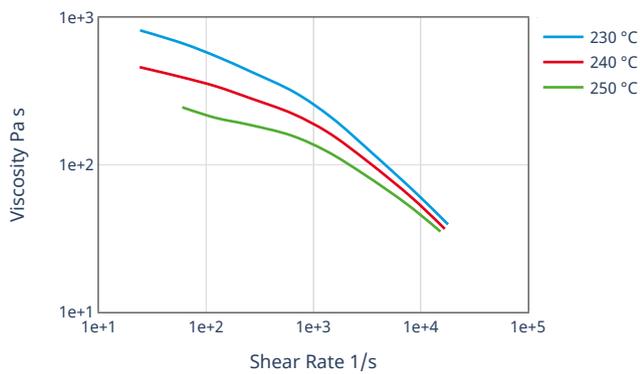
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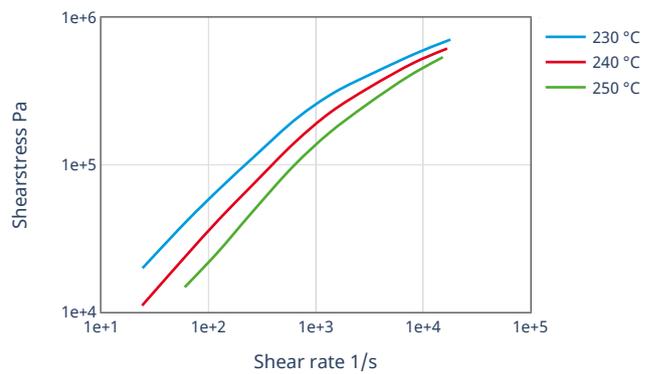
Thermal Properties	Value	Unit	Standard
Vicat softening temperature, B	90	°C	ISO 306
Other Properties	Value	Unit	Standard
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1270	kg/m <sup>3</sup>	ISO 1183

## Diagrams

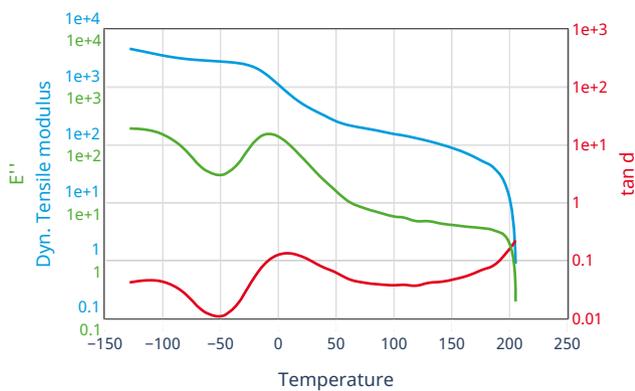
Viscosity-shear rate



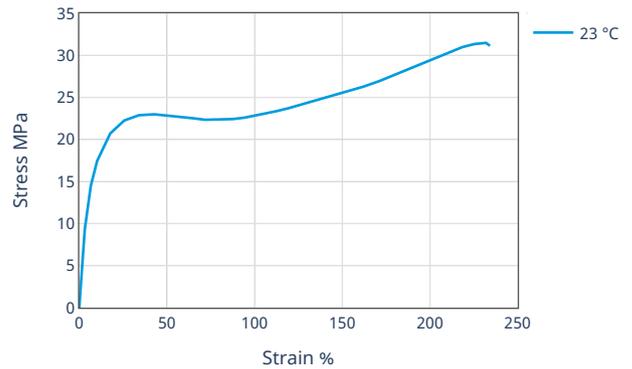
Shearstress-shear rate



Dynamic tensile modulus-temperature



Stress-strain (TPE)



## Processing Information

### Injection molding

Injection Molding Recommendations

Steel recommendations for molds screws and barrels

Trouble shooting guideline for injection molding

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Other extrusion

Extrusion guideline Arnitel® C and Arnitel® U

Arnitel® Recommendations for Extrusion