

TECHNICAL DATA SHEET

Arnitel® EL250

Envalior
TPC

Processing

Injection molding

Delivery Form

Pellets

Certifications

Food contact

Product Text

Product Information

Injection Molding, Food Contact Quality

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	48	cm ³ /10min	ISO 1133
Temperature	230	°C	
Load	2.16	kg	
Density of melt	905	kg/m ³	
Mechanical Properties	Value	Unit	Standard
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
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
Tensile notched impact strength, +23°C	N	kJ/m ²	ISO 8256/1
Stress at 10% elongation	2.1	MPa	ISO 527
Stress at 100% elongation	5.1	MPa	
Strain at break TPE	>300	%	ISO 527
Stress at break TPE	15	MPa	ISO 527
Shore A hardness, 15s	85		ISO 7619-1
Thermal Properties	Value	Unit	Standard
Melting temperature, 10°C/min	180	°C	ISO 11357-1/-3

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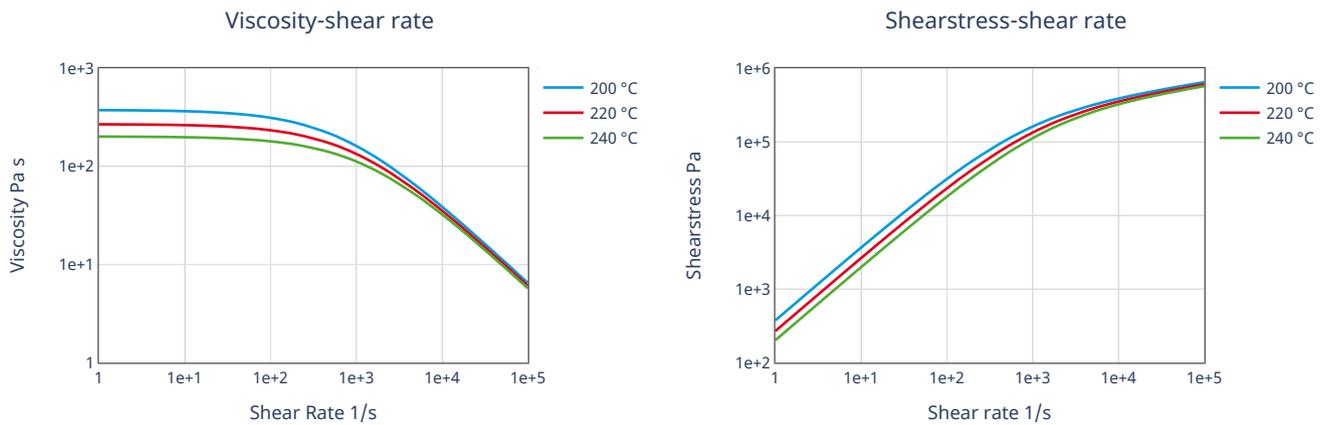
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Thermal Properties	Value	Unit	Standard
Glass transition temperature, 10°C/min	-80	°C	ISO 11357-1/-2
Coeff. of linear therm. expansion, parallel	220	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	220	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	
Yellow card available	yes		

Electrical Properties	Value	Unit	Standard
Volume resistivity	5E12	Ohm*m	IEC 62631-3-1

Other Properties	Value	Unit	Standard
Water absorption	0.8	%	Sim. to ISO 62
Density	1080	kg/m ³	ISO 1183

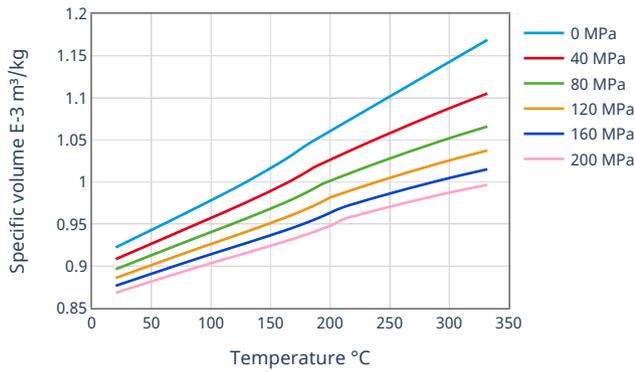
Diagrams



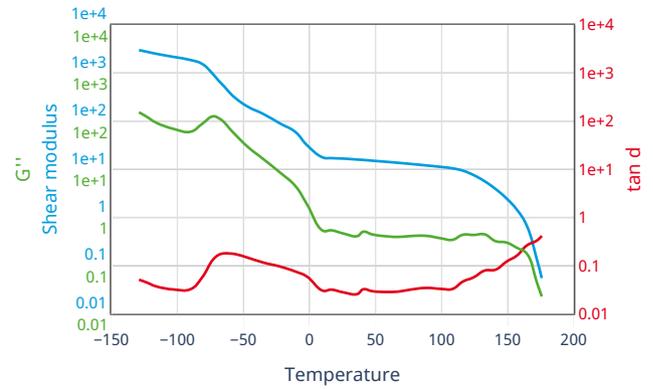
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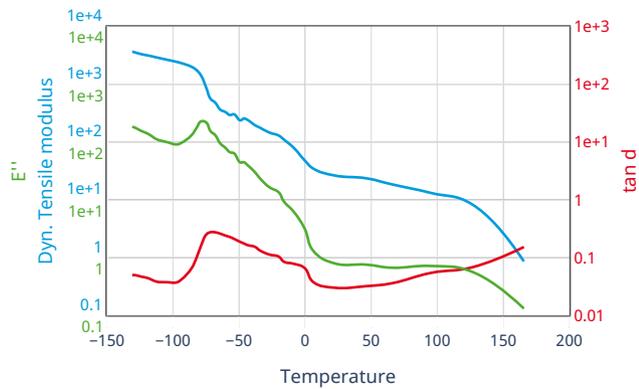
Spec. volume-Temperature (pVT)



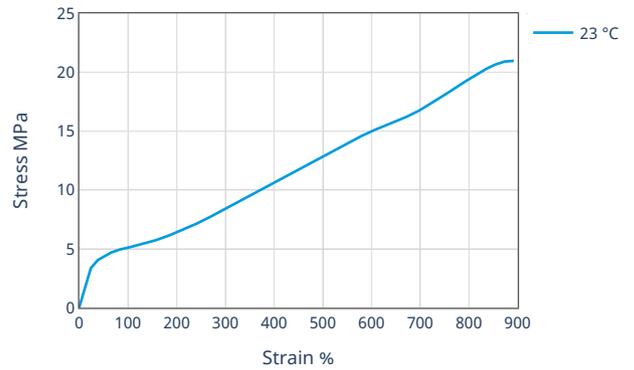
Dynamic shear modulus-temperature



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