

TECHNICAL DATA SHEET

# Arnitel® EL630

Envalior  
TPC

**Processing**

Injection molding

Pellets

**Certifications**

Food contact

**Delivery Form**

## Product Text

**Product Information**

Injection Molding, Food Contact Quality

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	28	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	12	kJ/m <sup>2</sup>	ISO 179/1eA
Tensile notched impact strength, +23°C	233	kJ/m <sup>2</sup>	ISO 8256/1
Stress at 10% elongation	17	MPa	ISO 527
Stress at 100% elongation	18	MPa	
Stress at 300% elongation	20	MPa	ISO 527
Strain at break TPE	>300	%	ISO 527
Stress at break TPE	35	MPa	ISO 527
Compression set at 70 °C, 24h	43	%	ISO 815
Thermal Properties	Value	Unit	Standard
Melting temperature, 10°C/min	212	°C	ISO 11357-1/-3

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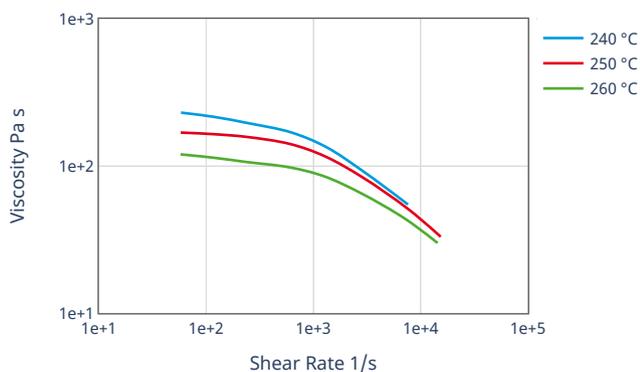
Thermal Properties	Value	Unit	Standard
Glass transition temperature, 10°C/min	-60	°C	ISO 11357-1/-2
Temp. of deflection under load, 0.45 MPa	115	°C	ISO 75-1/-2
Vicat softening temperature, B	125	°C	ISO 306
Coeff. of linear therm. expansion, parallel	185	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	185	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
Relative permittivity, 100Hz	3.8		IEC 62631-2-1
Relative permittivity, 1MHz	3.4		IEC 62631-2-1
Dissipation factor, 100Hz	110	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	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		IEC 60112

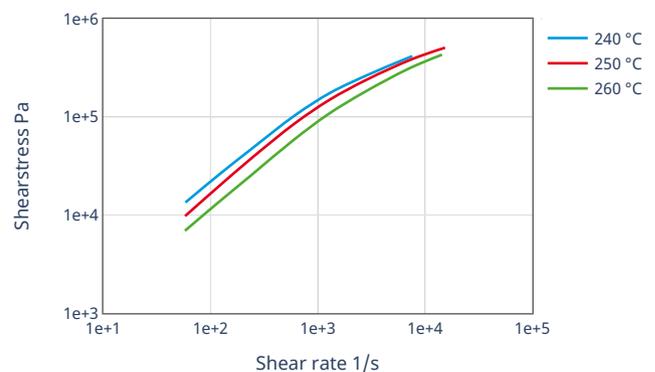
Other Properties	Value	Unit	Standard
Water absorption	0.6	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1240	kg/m <sup>3</sup>	ISO 1183

## Diagrams

Viscosity-shear rate



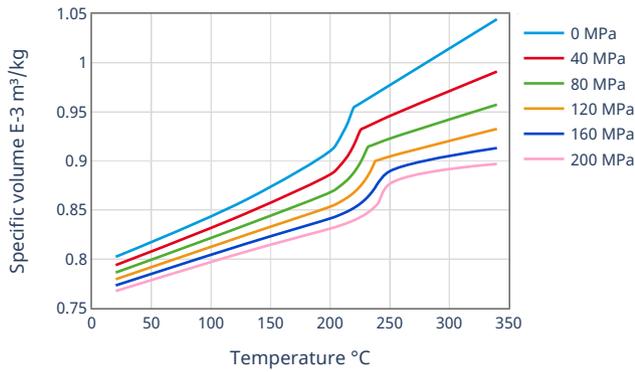
Shearstress-shear rate



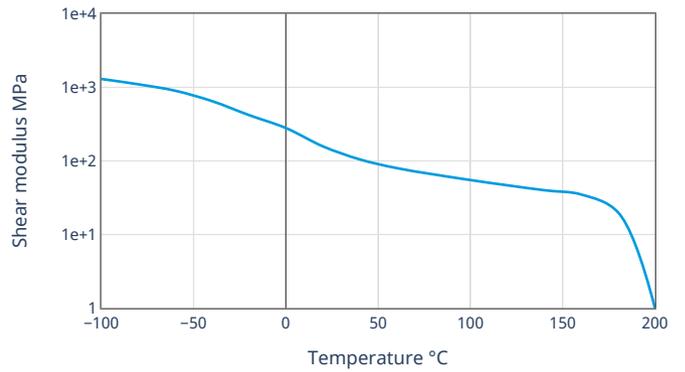
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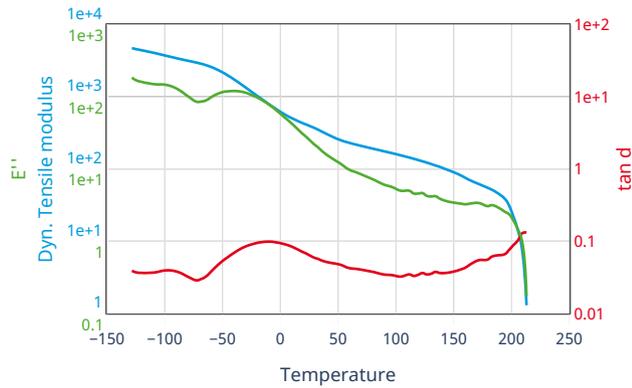
Spec. volume-Temperature (pVT)



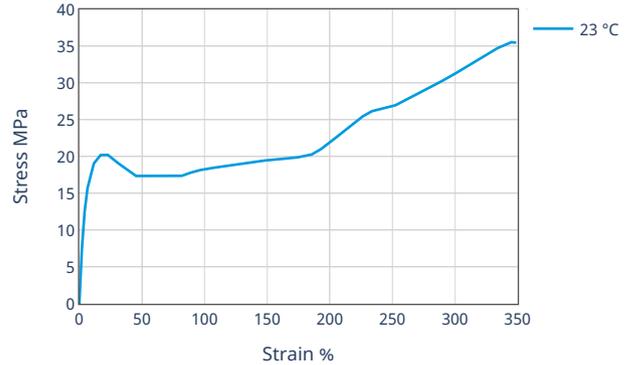
Dynamic shear modulus-temperature



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