

TECHNICAL DATA SHEET

# Arnitel® EM630-H

Envalior  
TPC

**Processing**

Injection molding, Other extrusion

**Delivery Form**

Pellets

**Additives**

Release agent

**Special Characteristics**

Heat stabilized or stable to heat

## Product Text

**Product Information**

Extrusion Grade, Heat Stabilized

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	3.7	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
Stress at 10% elongation	17	MPa	ISO 527
Stress at 100% elongation	21	MPa	
Stress at break TPE	27	MPa	ISO 527

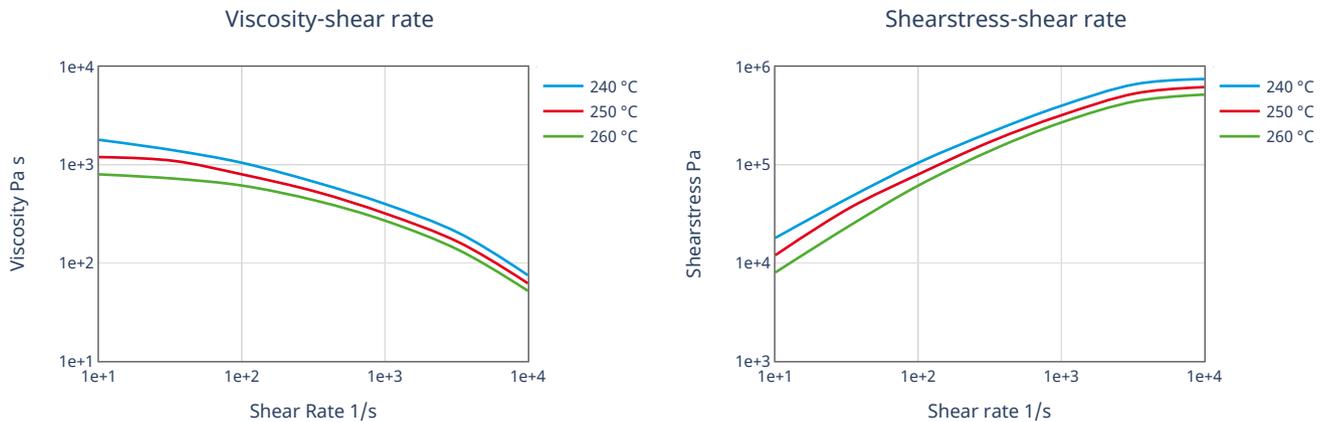
Thermal Properties	Value	Unit	Standard
Melting temperature, 10°C/min	212	°C	ISO 11357-1/-3
Vicat softening temperature, B	125	°C	ISO 306
Coeff. of linear therm. expansion, parallel	150	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	150	E-6/K	ISO 11359-1/-2

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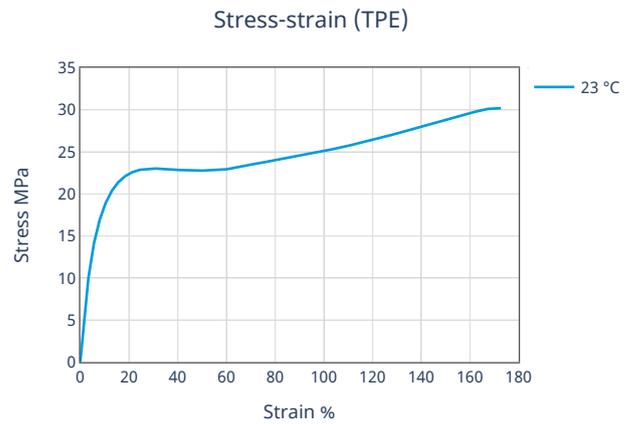
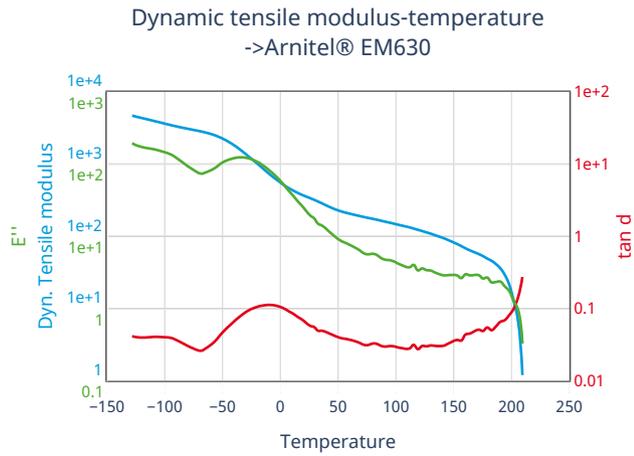
Electrical Properties	Value	Unit	Standard
Relative permittivity, 1MHz	4.1		IEC 62631-2-1
Dissipation factor, 1MHz	170	E-4	IEC 62631-2-1
Volume resistivity	1.2E11	Ohm*m	IEC 62631-3-1
Electric strength	22	kV/mm	IEC 60243-1
Comparative tracking index	600		IEC 60112
Other Properties	Value	Unit	Standard
Water absorption	0.63	%	Sim. to ISO 62
Humidity absorption	0.18	%	Sim. to ISO 62
Density	1235	kg/m <sup>3</sup>	ISO 1183
Test Specimen Production	Value	Unit	Standard
Injection molding, melt temperature	240	°C	ISO 294
Injection molding, mold temperature	35	°C	ISO 294
Injection molding, injection velocity	500	mm/s	ISO 294

## Diagrams



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## Processing Information

### Injection molding

Steel recommendations for molds screws and barrels  
Trouble shooting guideline for injection molding

### Other extrusion

Arnitel® E & P tube manufacturing guidelines  
Arnitel® Recommendations for Extrusion