

# Arnitel<sup>®</sup> EM630

## TPC—ET

Extrusion Grade, Food Contact Quality

Print Date: 2025–12–03

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>		VALUE	
Melt volume–flow rate	4	cm <sup>3</sup> /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage [parallel]	1.5	%	Sim. to ISO 294–4
Molding shrinkage [normal]	1.75	%	Sim. to ISO 294–4
<b>MECHANICAL PROPERTIES</b>		VALUE	
Shore D Hardness (3s)	60	—	ISO 868
Tensile modulus	275	MPa	ISO 527–1/–2
Stress at break	27	MPa	ISO 527–1/–2
Nominal strain at break	220	%	ISO 527–1/–2
Stress at 5% strain	12	MPa	ISO 527–1/–2
Stress at 10% strain	17	MPa	ISO 527–1/–2
Stress at 50% strain	21	MPa	ISO 527–1/–2
Stress at 100% strain	21	MPa	ISO 527–1/–2
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
Izod notched impact strength (+23°C)	N	kJ/m <sup>2</sup>	ISO 180/1A
Flexural modulus	280	MPa	ISO 178
<b>MECHANICAL PROPERTIES (DIE CUTTING)</b>		VALUE	
Stress at break (normal)	49	MPa	ISO 527–1/–2

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PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
Tear strength (normal)	144	kN/m	ISO 34-1; Method B
Tear strength (parallel)	161	kN/m	ISO 34-1; Method B
Strain at break (normal)	680	%	ISO 527-1/-2

THERMAL PROPERTIES	VALUE		
Melting temperature (10°C/min)	212	°C	ISO 11357-1/-3
Vicat softening temperature (50°C/h 50N)	125	°C	ISO 306
Coeff. of linear therm. expansion (parallel)	1.85	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	1.85	E-4/°C	ISO 11359-1/-2
Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10

ELECTRICAL PROPERTIES	VALUE		
Relative permittivity (100Hz)	3.8	—	IEC 62631-2-1
Relative permittivity (1 MHz)	3.4	—	IEC 62631-2-1
Dissipation factor (100 Hz)	110	E-4	IEC 62631-2-1
Dissipation factor (1 MHz)	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	V	IEC 60112

OTHER PROPERTIES	VALUE		
Density	1240	kg/m³	ISO 1183
Apparent density	760	kg/m³	ISO 60
Water absorption	0.6	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62

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