

# Arnitel<sup>®</sup> PM471

## TPC-ET

Injection Molding

Print Date: 2024-05-04

PROPERTIES	TYPICAL DATA	UNIT	TEST METHOD
<b>RHEOLOGICAL PROPERTIES</b>			
	<b>VALUE</b>		
Melt volume-flow rate	12.5	cm <sup>3</sup> /10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Molding shrinkage [parallel]	1.6	%	Sim. to ISO 294-4
Molding shrinkage [normal]	1.6	%	Sim. to ISO 294-4

<b>MECHANICAL PROPERTIES</b>			
	<b>VALUE</b>		
Shore D Hardness (3s)	44	—	ISO 868
Tensile modulus	170	MPa	ISO 527-1/-2
Stress at break	15	MPa	ISO 527-1/-2
Nominal strain at break	165	%	ISO 527-1/-2
Stress at 5% strain	6.4	MPa	ISO 527-1/-2
Stress at 10% strain	8.8	MPa	ISO 527-1/-2
Stress at 50% strain	11	MPa	ISO 527-1/-2
Stress at 100% strain	12	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)	N	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength (+23°C)	N	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength (-30°C)	N	kJ/m <sup>2</sup>	ISO 180/1A
Flexural modulus	160	MPa	ISO 178

### MECHANICAL PROPERTIES (DIE CUTTING) VALUE

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## Property Data

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<i>PROPERTIES</i>	<i>TYPICAL DATA</i>	<i>UNIT</i>	<i>TEST METHOD</i>
Stress at break (normal)	16	MPa	ISO 527-1/-2
Tear strength (normal)	75	kN/m	ISO 34-1; Method B
Tear strength (parallel)	74	kN/m	ISO 34-1; Method B
Strain at break (normal)	320	%	ISO 527-1/-2
<i>THERMAL PROPERTIES</i>		<i>VALUE</i>	
Melting temperature (10°C/min)	217	°C	ISO 11357-1/-3
<i>OTHER PROPERTIES</i>		<i>VALUE</i>	
Density	1200	kg/m <sup>3</sup>	ISO 1183

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