

Product Texts

Extrusion Grade, Food Contact Quality

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	4	cm ³ /10min	ISO 1133
Temperature	230	°C	-
Load	2.16	kg	-
^[C] Density of melt	900	kg/m ³	-
^[C] Thermal conductivity of melt	0.1	W/(m K)	-
^[C] Spec. heat capacity of melt	1900	J/(kg K)	-
^[C] Eff. thermal diffusivity	5.85E-8	m ² /s	-
^[C] Ejection temperature	160	°C	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	15	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	8	kJ/m ²	ISO 179/1eA
^[C] Stress at 10% elongation	36	MPa	ISO 527
^[C] Stress at break TPE	26	MPa	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	221	°C	ISO 11357-1/-3
^[C] Vicat softening temperature, B	160	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	165	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	165	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.7	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.4	-	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	400	E-4	IEC 62631-2-1
^[C] Volume resistivity	1E13	Ohm*m	IEC 62631-3-1
^[C] Electric strength	23	kV/mm	IEC 60243-1
^[C] Comparative tracking index	600	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.6	%	Sim. to ISO 62
^[C] Humidity absorption	0.15	%	Sim. to ISO 62
^[C] Density	1290	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] 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
[C]: CAMPUS

Characteristics**Processing**

Injection Molding, Other Extrusion

Certifications

Food contact

Delivery form

Pellets

Regional Availability

North America, Europe

Additives

Release agent

Other text 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](#)