

Arnitel® CM622

Thermoplastic Copolyester Elastomer
DSM Engineering Plastics

Message:

Arnitel® CM622 is a Thermoplastic Copolyester Elastomer (TPC-ES) material. It is available in Asia Pacific, Europe, or North America for extrusion.

General Information			
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	9.00	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 3 sec)	60		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	310	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Break	33.0	MPa	
5.0% Strain	14.5	MPa	
10% Strain	19.8	MPa	
50% Strain	22.0	MPa	
100% Strain	20.4	MPa	
Nominal Tensile Strain at Break	590	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	7.0	kJ/m ²	
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	190	°C	ISO 306/A50
--	87.0	°C	ISO 306/B50
Melting Temperature ¹	208	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	100	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	220 to 240	°C	
Nozzle Temperature	230 to 250	°C	
Processing (Melt) Temp	230 to 250	°C	

Mold Temperature	20.0 to 50.0	°C
Injection Rate	Moderate-Fast	
Back Pressure	3.00 to 10.0	MPa
Screw Compression Ratio	2.5:1.0	

NOTE

1.
- 10°C/min

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Recommended distributors for this material

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