

Arnitel® PL650

Thermoplastic Copolyester Elastomer
DSM Engineering Plastics

Message:

Arnitel® PL650 is a Thermoplastic Copolyester Elastomer (TPC-ET) material. It is available in Asia Pacific, Europe, or North America for injection molding.
Primary attribute of Arnitel® PL650: Flame Rated.

General Information			
UL YellowCard	E47960-240196		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	26.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 3 sec)	62		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	430	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Break	35.0	MPa	
5.0% Strain	17.1	MPa	
10% Strain	22.1	MPa	
50% Strain	22.9	MPa	
100% Strain	22.1	MPa	
Nominal Tensile Strain at Break	370	%	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	23	kJ/m ²	
Notched Izod Impact Strength			ISO 180/1A
-20°C	5.0	kJ/m ²	
23°C	21	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ¹	221	°C	ISO 11357-3
Flammability	Nominal Value		Test Method
Flammability Classification (1.50 mm)	HB		IEC 60695-11-10, -20
Injection	Nominal Value	Unit	
Drying Temperature	110	°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

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

