

Arnitel® PL460-S

Thermoplastic Copolyester Elastomer
DSM Engineering Plastics

Message:

Arnitel® PL460-S is a Thermoplastic Copolyester Elastomer (TPC-ET) material. It is available in Asia Pacific, Europe, or North America for injection molding. Important attributes of Arnitel® PL460-S are:
Flame Rated
Flame Retardant

General Information			
UL YellowCard	E43392-235338	E47960-240183	
Additive	Flame Retardant		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (240°C/2.16 kg)	18.0	cm ³ /10min	ISO 1133
Water Absorption			ISO 62
Saturation, 23°C	3.5	%	
Equilibrium, 23°C, 50% RH	0.40	%	
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	60		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	240	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Break	21.3	MPa	
10% Strain	10.6	MPa	
100% Strain	16.1	MPa	
Nominal Tensile Strain at Break	240	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	22	kJ/m ²	
23°C	60	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ¹	220	°C	ISO 11357-3
Electrical	Nominal Value		Test Method
Relative Permittivity			IEC 60250
100 Hz	5.30		
1 MHz	4.80		
Flammability	Nominal Value		Test Method

Flammability Classification (1.50 mm)	V-0	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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