

Arnitel® EL250

Thermoplastic Copolyester Elastomer
DSM Engineering Plastics

Message:

Arnitel® EL250 is a Thermoplastic Copolyester Elastomer (TPC-ET) material. It is available in Asia Pacific, Europe, or North America for injection molding.

General Information			
UL YellowCard	E47960-475038		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Apparent Density	0.65	g/cm ³	ISO 60
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	41.0	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.80	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 3 sec)	25		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	25.0	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Break	16.0	MPa	
5.0% Strain	1.20	MPa	
10% Strain	2.10	MPa	
50% Strain	4.40	MPa	
100% Strain	5.10	MPa	
Nominal Tensile Strain at Break	900	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength			ISO 180/1A
-20°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ¹	180	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow	2.2E-4	cm/cm/°C	
Transverse	2.2E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.0E+14	ohms · cm	IEC 60093

Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	4.0 to 6.0	hr
Rear Temperature	190 to 210	°C
Middle Temperature	200 to 220	°C
Front Temperature	210 to 230	°C
Nozzle Temperature	220 to 240	°C
Processing (Melt) Temp	220 to 240	°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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