

Arnitel® EM400-BP

Thermoplastic Copolyester Elastomer
DSM Engineering Plastics

Message:

Arnitel® EM400-BP is a Thermoplastic Copolyester Elastomer (TPC-ET) material. It is available in Europe for extrusion or injection molding. Primary attribute of Arnitel® EM400-BP: Flame Rated.

General Information			
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	30	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	30.0	cm ³ /10min	ISO 1133
Water Absorption			ISO 62
Saturation, 23°C	0.75	%	
Equilibrium, 23°C, 50% RH	0.30	%	
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 15 sec)	34		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	50.0	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Break	25.0	MPa	
10% Strain	3.90	MPa	
100% Strain	7.50	MPa	
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	195	°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	1.0E+15	ohms·cm	IEC 60093
Electric Strength	20	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	4.10		
1 MHz	4.00		
Dissipation Factor			IEC 60250
100 Hz	1.0E-3		
1 MHz	0.017		
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification (1.60 mm)	HB		IEC 60695-11-10, -20
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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