

Arnitel® PL420-H

Thermoplastic Copolyester Elastomer

DSM Engineering Plastics

Message:

Arnitel® PL420-H 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® PL420-H are:

Flame Rated

Heat Stabilizer

Typical application of Arnitel® PL420-H: Automotive

General Information			
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	23.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	100	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Break	17.5	MPa	
10% Strain	5.30	MPa	
100% Strain	10.8	MPa	
Nominal Tensile Strain at Break	400	%	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
-30°C	No Break		
-20°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	220	°C	ISO 11357-3
Flammability	Nominal Value		Test Method
Flammability Classification			IEC 60695-11-10, -20
1.50 mm	HB		
3.00 mm	HB		
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	

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Recommended distributors for this material

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