Measurement of Maximum Permissible Exposure

1. Foreword

In adopt with the Human Exposure IEEE C95.1, and according to the FCC 1.1310. The *Maximum Permissible Exposure (MPE)* is obligated to measure in order to prove the safety of radiation harmfulness to the human body.

The *Gain* of the antenna used is measured in an *Anechoic chamber*. The *maximum total power to the antenna* is to be recorded. By adopting the ***Friis Transmission Formula*** and the *power gain of the antenna,* we can find the distance right away from the product, where the limit of the MPE is.

2. Description of EUT

FCC ID	**:**	RAFXWL-11GCAR
Product name	**:**	X-Micro WLAN 11g PCI Card (108Mbps)
Model name	**:**	XWL-11GCAR
Classification	**:**	Mobile Device (i) Under normal use condition, the antenna is at least 20cm away from the user; (ii) Warning statement for keeping 20cm separation distance and the prohibition of operating next to the person has been printed in the user's manual
Frequency Range	**:**	2.412 GHz ~ 2.462GHz
Supported Channel	**:**	11 Channels
Modulation Skill	**:**	DBPSK, DQPSK, CCK, OFDM
Power Type	**:**	Powered by PCI of client's device

3. Limits for *Maximum Permissible Exposure (MPE)*

Frequency Range (MHz)	Electric Field Strength (V/m)	Magnetic Filed Strength (H) (A/m)	Power Density (S) (mW/cm2)	Averaging Time $\|E\|^2$, $\|H\|^2$ or S (minutes)
(A) Limits for Occupational/Controlled Exposure				
0.3-3.0	614	1.63	100	6
3.0-30	1842/f	4.89/f	$900/f^2$	6
30-300	61.4	0.163	1.0	6
300-1500	--	--	f/300	6
1500-100,000	--	--	5	6
(B) Limits for General Population/Uncontrolled Exposure				
0.3-1.34	614	1.63	100	30
1.34-30	824/f	2.19/f	$180/f^2$	30
30-300	27.5	0.073	0.2	30
300-1500	--	--	f/1500	30
1500-100,000	--	--	1.0	30

[The EUT is tested in transmit and receive modes and in the first, middle and the last channel separately. The following shows only our observation have the greatest emissions.]

According to **OET BULLETIN 56 Fourth Edition/August 1999**, **Equation for Predicting RF Fields:**

Friis Transmission Formula: $S = \frac{PG}{4\pi R^2} = \frac{220.29 \times 1.514}{4\pi (20)^2} = 0.066 mW/cm^2$

Estimated safe separation: $R = \sqrt{\frac{PG}{4\pi}} = \sqrt{\frac{220.29x1.514}{4\pi}} = 5.152 cm$

Remarks: "The safe estimated separation that the user must maintain from the antenna is at least 5.152 cm."

Where: S = *power density* (in appropriate units, e.g. mW/cm2)

P = *power input* to the antenna (in appropriate units, e.g., mW)

G = *power gain* of the antenna in the direction of interest relative to an isotropic radiator

R = *distance* to the center of radiation of the antenna (appropriate units, e.g., cm)

The *Numeric gain G* of antenna with a gain specified in dB is determined by:

$G = \text{Log}^{-1}$ (***dB*** antenna gain / 10)

$G = \text{Log}^{-1}$ (1.80 / 10) = 1.51356

Appendix

Antenna Specification

WHA YU INDUSTRIAL CO., LTD. (HEAD OFFICE)

TAI HWA ELECTRONIC CO., LTD.(CHINA)

SHANGHAI HUA YU ELECTRONIC CO., LTD.(CHINA)

SPECIFICATION FOR APPROVAL

CUSTOMER: *友勁科技股份有限公司*

PART NAME: *2.4G RF Antenna Assembly*

PART NO: *11723B02*317*00*

W. Y. P/NO.: *C056-510131-A* *REV.: X1*

	MANUFACTURER SIGNATURE	CUSTOMER SIGNATURE
APPROVED BY :		
DATE :		

WHA YU GROUP

WHA YU INDUSTRIAL CO., LTD.(HEAD OFFICE)

譁裕實業股份有限公司

Tel:+886-3-5714225(REP.)

Fax:+ 886-3-5713853 · + 886-3-5723600

TAI HWA ELECTRONC CO., LTD. (CHINA)

台樺電業制品廠

Address: Pak Ho District, Hiu Street Town, Dong Guan City, Guangdong, China

Tel: + 86-769-5599375 · + 86-769-5912375

Fax: + 86-769-5599376

SHANGHAI HUA YU ELECTRONIC CO., LTD. (CHINA)

上海譁裕電子有限公司

Address: Lian Ho Village Bai Ho Town, Qing Pu Country Shanghai, China

Tel: + 86-21-59741348 · + 86-21-59743624

Fax: + 86-21-59741347

INDEX

RF Antenna Cable Assembly

Specification

1. Electrical Properties :

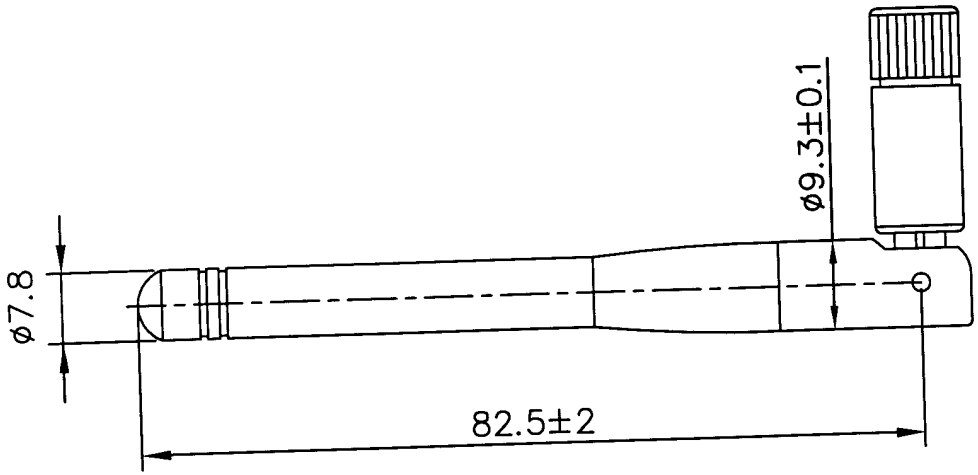
1.1 Frequency Rang..... 2.4GHz ~ 2.5GHz
1.2 Impedance ..... 50Ω Nominal
1.3 VSWR ..... 1.92 Max.
1.4 Return Loss..... -10dB Maximum
1.5 Electrical Wave..... 1/2 λ Diople
1.6 Gain..... 1.8 dBi
1.7 Admitted Power..... 1W

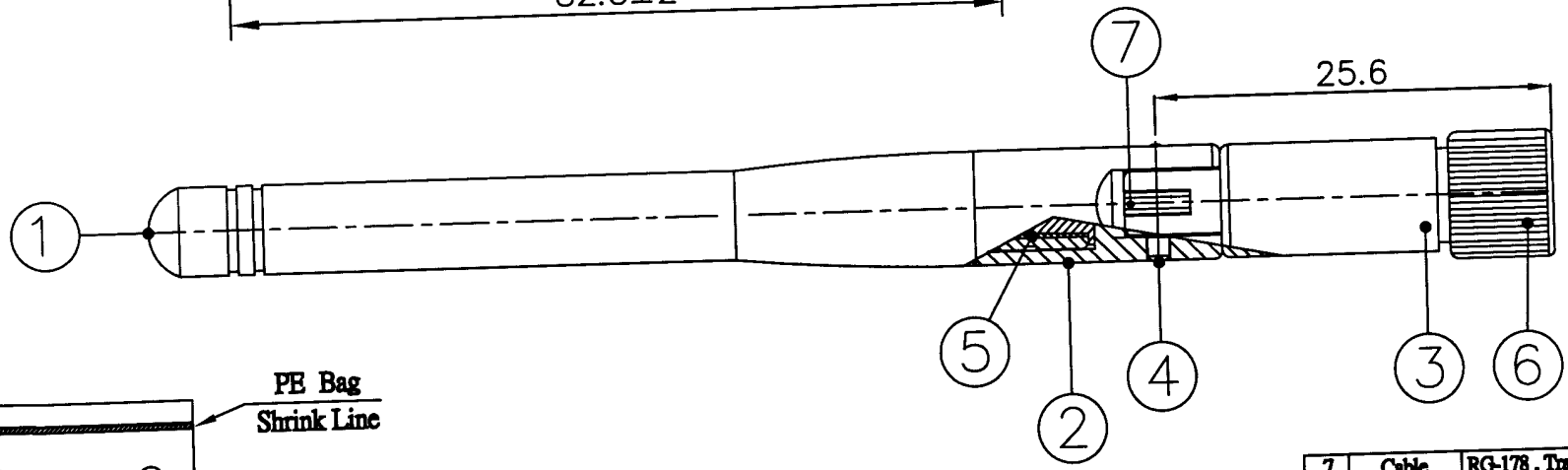
2. Physical Properties :

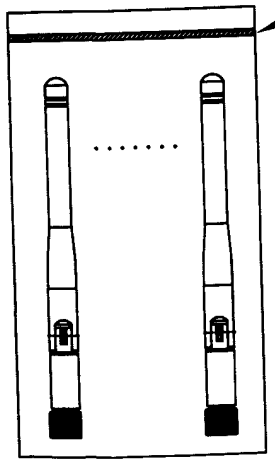
2.1 Cable..... RG-178 Cable
2.2 Antenna Cover..... TPE
2.3 Antenna Base..... PC
2.4 Operating Temp. .....-20℃ ~ +65℃
2.5 Storage Temp. .....-30℃ ~ +75℃
2.6 Color .....Black
2.7 Connector..... SMA Plug Reverse

REV	DATE	DESCRIPTION
X1	11/17-2003	New Issue

CG-







Packing : 25 pcs/bag

NO	DESCRIPTION		QTY	REMARK
7	Cable	RG-178 , Translucent Brown ; 50 Ω	1	
6	Connector	SMA Straight Plug/Reverse	1	
5	Ground Tube	Brass , Ni plated	1	
4	Rivet	Brass , Cr Plated (Black)	2	
3	Antenna Base	PC ; Color : Black	1	
2	Antenna Base	PC ; Color : Black	1	
1	Antenna Cover	TPE ; Color : Black	1	

CUSTOMER'S SINGATURE

XX.	±3.0
X.	±2.0
.X	±1.0
.XX	±0.5
.XXX	±0.1

APPROVED: Winston KF 11/19

CHECKED

DRAWING: Jane

CUSTOMER: 友勤科技股份有限公司

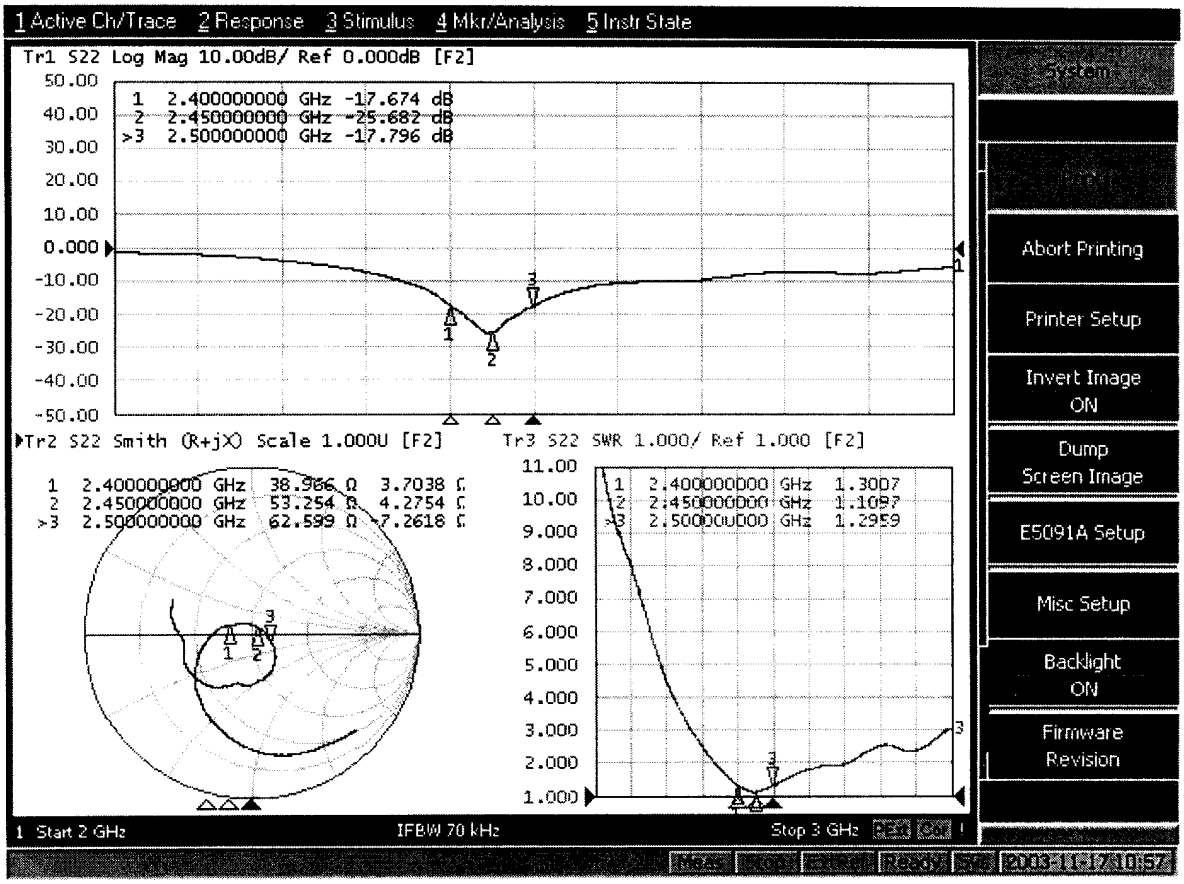
PART NO : 11723B02*317*00

PARTNAME: RF Antenna Assembly

W.Y P/NO : C056-510131-A

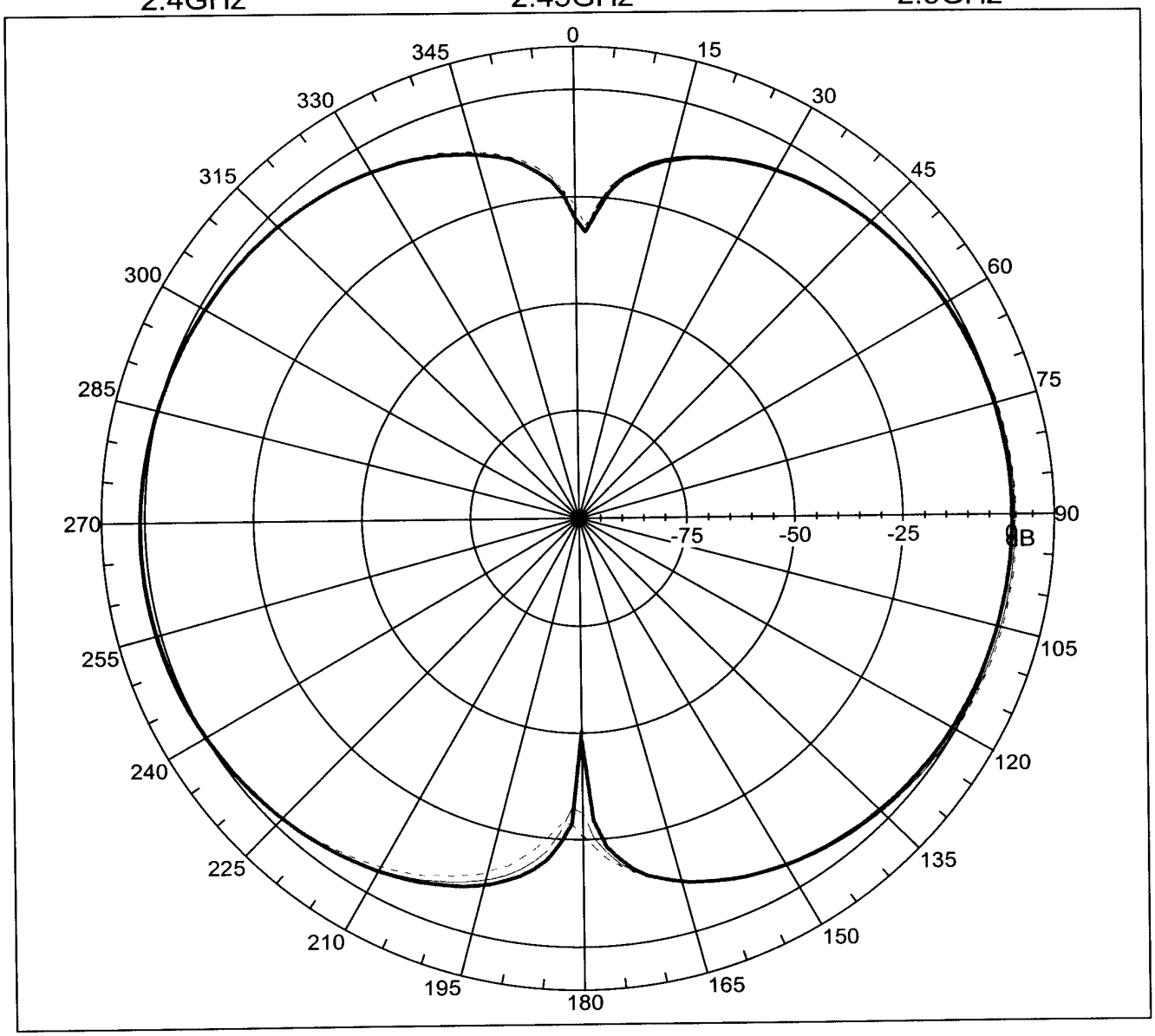
REV	UNIT	FILE :
X1	m/m	SHEET : 1/1

Wha Yu
INDUSTRIAL CO.,LTD.
譁裕實業股份有限公司


1 Active Ch/Trace 2 Response 3 Stimulus 4 Mkr/Analysis 5 Instr State
Tr1 S22 Log Mag 10.00dB/ Ref 0.000dB [F2]
1 2.400000000 GHz -17.674 dB
2 2.450000000 GHz -25.682 dB
>3 2.500000000 GHz -17.796 dB
Tr2 S22 Smith (R+jX) Scale 1.000U [F2]
1 2.400000000 GHz 38.966 Ω 3.7038 Ω
2 2.450000000 GHz 53.254 Ω 4.2754 Ω
>3 2.500000000 GHz 62.599 Ω -7.2618 Ω
Tr3 S22 SWR 1.000/ Ref 1.000 [F2]
1 2.400000000 GHz 1.3007
2 2.450000000 GHz 1.1087
>3 2.500000000 GHz 1.2959
System
Abort Printing
Printer Setup
Invert Image ON
Dump Screen Image
E5091A Setup
Misc Setup
Backlight ON
Firmware Revision
1 Start 2 GHz
IFBW 70 kHz
Stop 3 GHz
Ready
2003-11-17 10:57

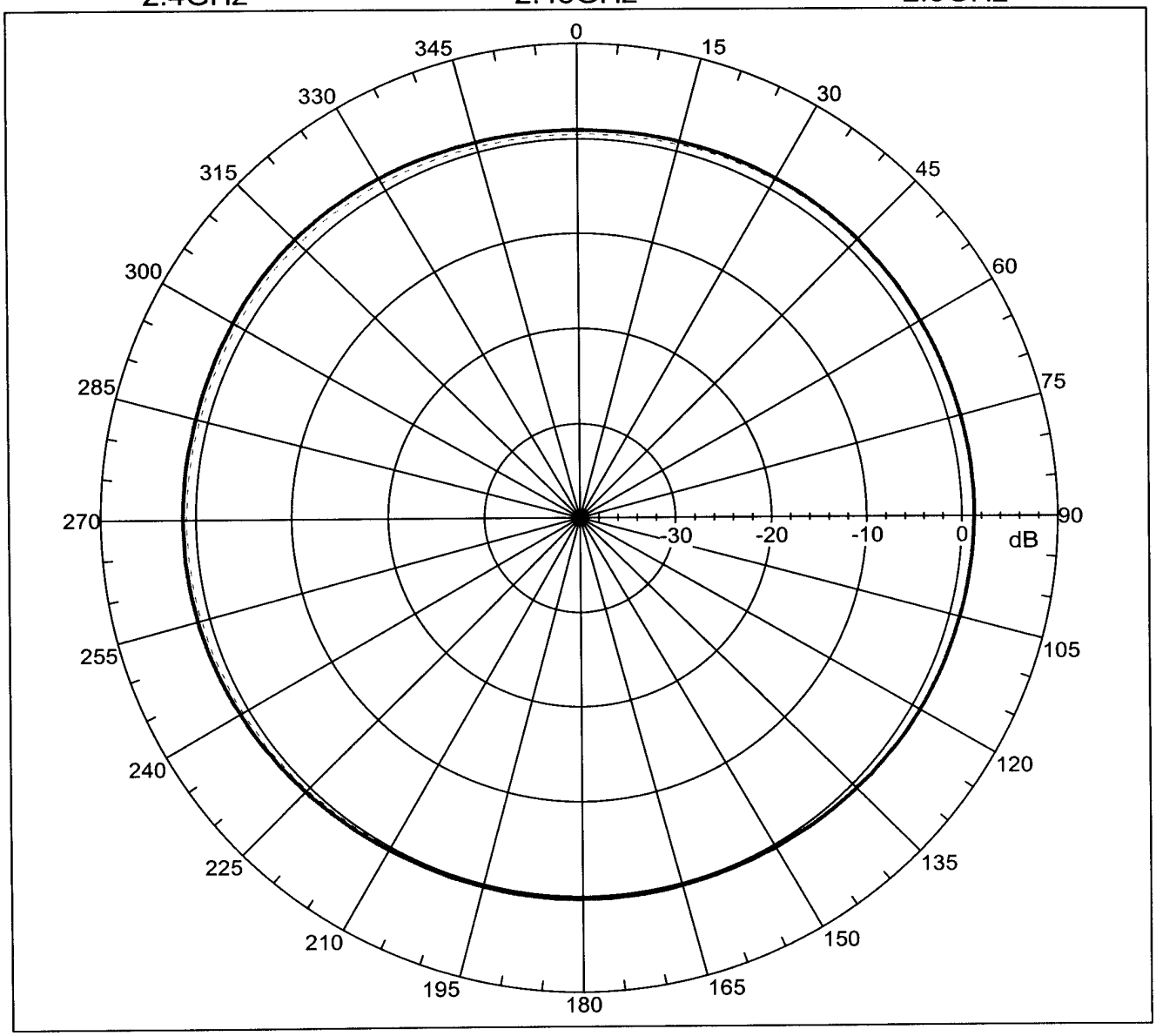
譁裕實業股份有限公司
WHA YU INDUSTRIAL CO., LTD

Far-field amplitude of 2.4GHz small dipole antenna-E-plane.nsi



華裕實業股份有限公司
WHA YU INDUSTRIAL CO., LTD

Far-field amplitude of 2.4GHz small dipole antenna-H-plane.nsi



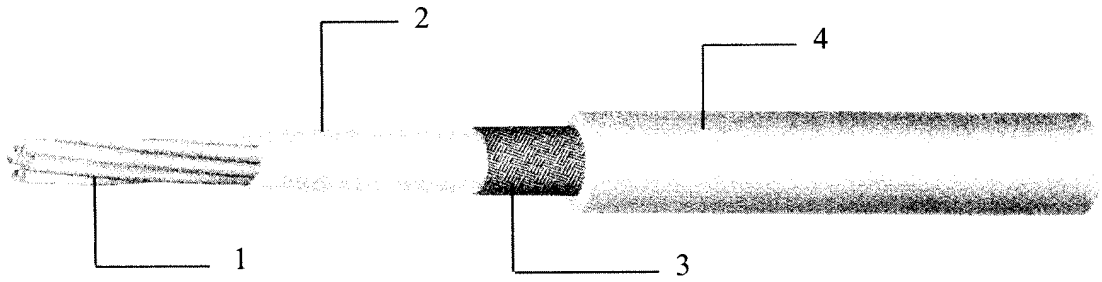
Nizing Electric Co., Ltd.
11-15 Santai Rd., Hsinchuang, Taipei Hsien, 242, Taiwan, R.O.C.
Tel: 02-29016164 Fax: 29050644 E-mail: shenbinnizing@yahoo.com.tw

RG 178 B/U	FEP INSULATED HIGH-FREQUENCY COAXIAL CABLE	PAGE	1 / 2
PRODUCT STANDARD		ISSUED	16. Oct. 2003
		REVISED	

I - Scope

This specification presents a FEP insulated high-frequency coaxial cable AWG 30, 1.8 mm O.D. for internal wiring of electronic equipment, such as Computer / Notebook with wireless communication systems.

II - Construction



Item		Unit	Details
1. Inner Conductor	Material	—	CP-AG
	Composition	No./mm	AWG 30 or 7 ×0.1
	Dia. (approx.)	mm	0.305
2. Dielectric	Material	—	Extruded FEP
	Nom. O.D.	mm	0.84 ± 0.05
	Color	—	Natural
3. Outer Conductor	Material	—	Silver coated copper
	Composition	—	Braided (16 / 3 / 0.1)
	Dia. (approx)	mm	1.29 ±0.01
4. Jacket	Material	—	Extruded FEP
	Dia.	mm	1.80 ±0.1
	Color	—	Standard color is Light Orange

Note :	MADE BY	
	APPROVALS	

WHA YU INDUSTRIAL CO., LTD.

NO. 88-3, SHUI LI ROAD, HSIN CHU CITY, TAIWAN 300
TEL: 886-3-5714225 FAX: 886-3-5713853
http://www.whayu.com.tw

QUOTATION

TO:	Archtech Electronics Corporation	NO.:	20031105
ATTN.:	Mr. Paul Foung	DATE:	05 Nov.,03
TEL:	732-432-5188	FROM:	Rebecca Wu
FAX:	732-432-5189	E-MAIL:	rebecca@whayu.com.tw

ITEM / PART NO.	QTY (PCS)	DESCRIPTION	Unit Price (USD)	Amount (USD)
		SC/SC MM DUP 3.0*2 62.5/125PVC 1M	$4.620	
		SC/SC MM DUP 3.0*2 62.5/125PVC 2M	$5.080	
		SC/SC MM DUP 3.0*2 62.5/125PVC 3M	$5.550	
		SC/SC MM DUP 3.0*2 62.5/125PVC 4M	$6.020	
		SC/SC MM DUP 3.0*2 62.5/125PVC 5M	$6.490	
		SC/SC MM DUP 3.0*2 62.5/125PVC 6M	$6.950	
		SC/SC MM DUP 3.0*2 62.5/125PVC 7M	$7.420	
		SC/SC MM DUP 3.0*2 62.5/125PVC 8M	$7.890	
		SC/SC MM DUP 3.0*2 62.5/125PVC 9M	$8.350	
		SC/SC MM DUP 3.0*2 62.5/125PVC 10M	$8.880	

REMARK:

1. Price Term: FOB Shangahai
2. Lead time: 1-2 Weeks
3. Payment Term: T/T Net 30 days
4. Shipment: BY UPS Expedited ,Account No. 74W-6A3
5. The per shippment total weight is under 145KGS
6. Packing :

Sales Rep.: Rebecca Wu

Approval : Ken Chen

Cable Specification

Cable : Mil-C-17 Coaxial Cable RG-178

1. Construction :
   - 1 Conductor..... **30AWG 7/38 SCCS**
   - 2 Dielectric..... PTFE OD : 0.033"±0.002"
   - 3 Shielded.....38AWG SPC OD : 0.051" Nominal
   - 4 Jacket.....FEP OD : 0.071"±0.004"

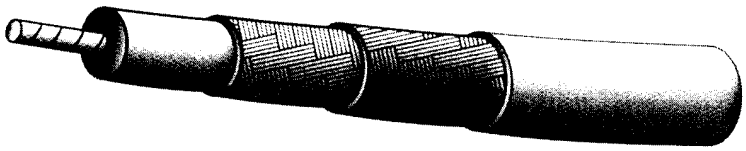
2. Physical Properities :
   - 1 Weight per 1000ft..... 6.3 lbs Maximum
   - 2 Bend Radius.....0.35" Mininum
   - 3 Operating Temperature Range -55℃~ 200℃

3. Electrical Properities:
   - 1 Impedance..... 50±2 ohms
   - 2 Capacitance..... 32 pF/ft Maximum
   - 3 Cut off Frequency..... 116 GHz
   - 4 Attenuation.....45.0 dB/100ft @ 1GHz
     64.4 dB/100ft @ 2GHz
     79.7 dB/100ft @ 3GHz
     92.7 dB/100ft @ 4GHz
     104.3 dB/100ft @ 5GHz
     115.0 dB/100ft @ 6GHz

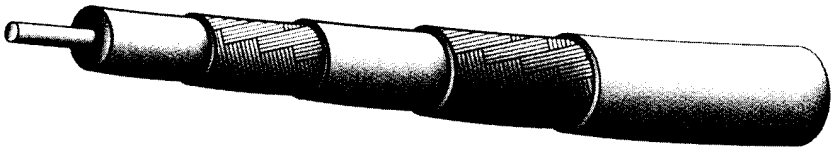
Mil-C-17 Coaxial Cable QPL Approved

Single braid

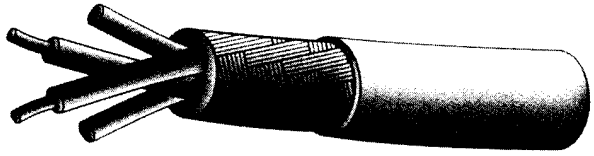
Double braid



Triax



Twinax



Harbour supplies a complete line of high temperature, high performance QPL approved MIL-C-17 coax cables for the military, commercial and industrial applications. The specific M17 constructions referenced are manufactured in accordance with the most recent revision of the MIL-C-17 specification. The MIL-C-17 specification defines complete physical and electrical characteristics for each M17 part number, including dimensional parameters, dielectric materials, shield construction, maximum attenuation, and VSWR levels.

VSWR Sweep Testing

When selecting a 50 ohm coaxial cable, constructions with VSWR requirements are recommended. Manufacturing and sweep testing cables with concern for VSWR ensures a quality cable free of spikes over the referenced frequency range. (Note the test frequencies specified in the electrical characteristics section.)

Precision PTFE Dielectrics

All of the high temperature, high performance coax cables listed have PTFE dielectrics with high dielectric strength and low capacitance in proportion to the dielectric constant. All PTFE dielectrics are manufactured with tolerances tighter than the MIL-C-17 specification to ensure uniformity of electrical characteristics, especially impedance, attenuation and VSWR.

Tape wrapped PTFE Constructions

Harbour also manufactures PTFE tape wrapped cables to a previous revision of the MIL-C-17 specification. These constructions can withstand operating temperatures up to 250° C. versus 200° C. for FEP jacketed cables. Also, PTFE tape wrapped cables are generally more flexible than their FEP jacketed counterparts.

UL Approvals

All of Harbour's M17 part numbers manufactured to the MIL-C-17 specification may be ordered with UL and FT4 approvals.

Mil-C-17 Coaxial Cables

Physical Characteristics:

M17 Number	Center Conductor	PTFE Dielectric Diameter	Shield	Jacket	Overall Diameter	Minimum Recommended Bend Radius	Operating Temp. (°C)	Weight (lbs/MFT)	Comments
M17/60-RG142	.037" SCCS	**.116"**	SPC(2)	FEP	.195"	**1.0"**	-55 +200	**43.0**	
M17/93-RG178	.0120"(7/.004")SCCS	**.033"**	SPC	FEP	.071"	**0.4"**	-55 +200	**6.3**	
M17/93-00001	.0120"(7/.004")SCCS	**.033"**	SPC	PFA	.071"	**0.4"**	-55 +230	**6.3**	M17/93-RG178 w/extended temp. ra
M17/94-RG179	.0120"(7/.004")SCCS	**.063"**	SPC	FEP	.100"	**0.4"**	-55 +200	**10.8**	
M17/95-RG180	.0120"(7/.004")SCCS	**.102"**	SPC	FEP	.141"	**0.7"**	-55 +200	**19.8**	
M17/110-RG302	.0253"SCCS	**.146"**	SPC	FEP	.202"	**1.0"**	-55 +200	**40.0**	
M17/111-RG303	.037"SCCS	**.116"**	SPC	FEP	.170"	**0.9"**	-55 +200	**31.0**	
M17/112-RG304	.059" SCCS	**.185"**	SPC(2)	FEP	.280"	**1.4"**	-55 +200	**94.0**	
M17/113-RG316	.0201"(7/.0067")SCCS	**.060"**	SPC	FEP	.098"	**0.5"**	-55 +200	**12.2**	
M17/127-RG393	.094"(7/.0312")SC	**.285"**	SPC(2)	FEP	.390"	**2.0"**	-55 +200	**165.0**	
M17/128-RG400	.0384"(19/.008")SC	**.116"**	SPC(2)	FEP	.195"	**1.0"**	-55 +200	**50.0**	
M17/131-RG403	.0120"(7/.004")SCCS	**.033"**	SPC(2)	FEP(2)	.116"	**0.6"**	-55 +200	**15.0**	Triaxial M17/93-RG
M17/152-00001	.0201"(7/.0067")SCCS	**.060"**	SPC(2)	FEP	.114"	**0.6"**	-55 +200	**18.5**	Double shielded M17/113-RG316
M17/158-00001	.037"SCCS	**.116"**	SPC(2)	FEP	.195"	**1.0"**	-55 +200	**56.0**	Unswept M17/60-RC
M17/169-00001	.0120"(7/.004")SCCS	**.033"**	SPC	FEP	.071"	**0.4"**	-55 +200	**6.3**	Unswept M17/93-RC
M17/170-00001	.037"(SCCS	**.116"**	SPC	FEP	.170"	**0.9"**	-55 +200	**39.0**	Unswept M17/111-RC
M17/172-00001	.0201"(7/.0067")SCCS	**.060"**	SPC	FEP	.098"	**0.5"**	-55 +200	**11.5**	Unswept M17/113-RC
M17/174-00001	.094"(7/.0312")SCCS	**.285"**	SPC(2)	FEP	.390"	**2.0"**	-55 +200	**175.0**	Unswept M17/127-RC
M17/175-00001	.0384"(19/.008")SC	**.116"**	SPC(2)	FEP	.390"	**1.0"**	-55 +200	**50.0**	Unswept M17/128-RC
M17/176-00002	.0235"(19/.005")SPA(2)	**.042"**	SPA	PFA	.129"	**0.6"**	-55 +230	**18.0**	Controlled impedar twinax
PTFE Tape Wrap Jacketed RG Cables									
RG 187 A/U	.0120"(7/.004)SCCS	**.063**	SPC	PTFE	.100"	**0.5"**	-55 +250	**10.0**	Flexible, 250° C. rat
RG 188 A/U	.0201"(7/.0067)SCCS	**.060**	SPC	PTFE	.100"	**0.5"**	-55 +250	**11.0**	Flexible, 250° C. rat
RG 195 A/U	.0120"(7/.004)SCCS	**.102**	SPC	PTFE	.141"	**0.7"**	-55 +250	**18.0**	Flexible, 250° C. rat
RG 196 A/U	.0120"(7/.004)SCCS	**.034**	SPC	PTFE	.067"	**0.4"**	-55 +250	**6.0**	Flexible, 250° C. rat

Electrical Characteristics:

M17 Number	Impedence (ohms)	Capacitance (pF/ft)	Max. Operating Voltage (RMS)	Maximum attenuation (dB/100ft) @ 100 MHz	400 MHz	1 GHz	3 GHz	5 GHz	10 GHz	Max. Frequency (GHz)
M17/60-RG142	**50 +/- 2**	29.4	**1900**	5.5	**11.7**	19.0	**35.0**	48.0	-	17.4
M17/93-RG178	**50 +/- 2**	29.4	**1000**	16.0	**33.0**	52.0	**94.0**	-	-	3.0
M17/93-00001	**50 +/- 2**	29.4	**1000**	16.0	**33.0**	52.0	**94.0**	-	-	3.0
M17/94-RG179	**75 +/- 3**	19.4	**1200**	-	**21.0**	-	**-**	-	-	-
M17/95-RG180	**95 +/- 5**	16.4	**1500**	-	**17.0**	-	**-**	-	-	-
M17/110-RG302	**75 +/- 3**	19.4	**2300**	-	**8.0**	-	**26.0**	-	-	-
M17/111-RG303	**50 +/- 2**	29.4	**1900**	3.9	**8.0**	15.0	**28.0**	-	-	-
M17/112-RG304	**50 +/- 3**	29.4	**3000**	2.7	**6.4**	11.1	**22.0**	30.0	-	8.0
M17/113-RG316	**50 +/- 2**	29.4	**1200**	11.0	**21.0**	38.0	**58.0**	-	-	3.0
M17/127-RG393	**50 +/- 2**	29.4	**2500**	2.4	**5.0**	8.8	**18.0**	24.6	**37.0**	11.0
M17/128-RG400	**50 +/- 2**	29.4	**1900**	4.5	**10.5**	17.0	**38.0**	50.0	**78.0**	12.4
M17/131-RG403	**50 +/- 2**	29.4	**1000**	-	**37.0**	-	**-**	-	-	10.0
M17/152-00001	**50 +/- 2**	29.4	**1200**	11.5	**24.0**	40.0	**75.0**	110.0	**170.0**	12.4
M17/158-00001	**50 +/- 2**	29.4	**1900**	-	**9.5**	-	**-**	-	-	-
M17/169-00001	**50 +/- 2**	29.4	**1000**	-	**29.0**	-	**-**	-	-	-
M17/170-00001	**50 +/- 2**	29.4	**1900**	-	**8.6**	-	**-**	-	-	-
M17/172-00001	**50 +/- 2**	29.4	**1200**	-	**21.0**	-	**-**	-	-	-
M17/174-00001	**50 +/- 2**	29.4	**2500**	-	**5.0**	-	**-**	-	-	-
M17/175-00001	**50 +/- 2**	29.4	**1900**	-	**10.5**	-	**-**	-	-	-
M17/176-00001	**77 +/- 7**	19.0	**1000**	-	**-**	-	**-**	-	-	-
PTFE Tape Wrap **Jacketed RG** Cables										
RG 187 A/U	**75 +/- 3**	19.4	**1200**	-	**21.0**	-		-	-	3
RG 188 A/U	**50 +/- 2**	29.4	**1200**	11.0	**21.0**	38.0	**58.0**	-	-	3
RG 195 A/U	**95 +/- 5**	15.4	**1500**	-	**17.0**	-		-	-	3
RG 196 A/U	**50 +/- 2**	29.4	**1000**	-	**29.0**	-		-	-	-

"Maximum frequencies" are those as referenced on individual slant sheets of the MIL-C-17 specification. No values are given for unswept constructions as the specification recommends these cables should not be used above 400 MHz. (All figures referenced above are nominal unless otherwise specified.)

Arnitel
polyether esters
polyetherester
esters de polyether

天線桿套材質特性表

Units Einheiten Unites	EM400	EM460	EL550	EL630	EL740	PL380
	1.12	1.16	1.20	1.23	1.27	1.18
℃	195	185	202	212	221	197
μm/m.k	220	160	180	140	110	150
℃	\	\	110	115	120	\
℃	130	150	180	200	200	145
℃	\	50	85	115	150	\
%	0.30	0.30	0.20	0.20	0.15	0.40
%	0.75	0.70	0.55	0.60	0.90	7.0
*	HB	HB	HB	HB	HB	HB
Mpa	55	110	220	375	900	60
Mpa	4.0	7.1	13.2	20.2	26.9	3.5
Mpa	5.4	9.0	15.7	23	22.6	5.2
Mpa	8.4	11.4	16.6	22.0	26.3	8.5
Mpa	17	21	32	40	45	16
%	700	800	600	600	360	450
kj/㎡	NB	NB	NB	NB	NB	NB
kj/㎡	NB	NB	NB	NB	200	NB
kj/㎡	NB	NB	NB	NB	9	NB
kj/㎡	NB	NB	20	4	4	NB
	38	45	55	63	74	38
MV/m	\	\	\	\	\	\
Ω.cm	$5*10^{14}$	10^{14}	10^{14}	10^{14}	10^{12}	10^{12}
Ω	$>10^{13}$	$>10^{14}$	$>10^{14}$	$>10^{14}$	$>10^{10}$	$>10^{13}$
\	4.1	\	\	3.8	\	4.7
\	4.0	4.4	4.0	3.4	3.3	4.4
$x10^{14}$	10	\	\	3.8	\	310
$x10^{14}$	170	350	400	350	300	350
\	800	800	600	600	600	800
\	600	600	600	800	800	600

2.2 Product coding

The structure of the Arnitel productcodes is illustrated wirth the following example:

U M 55 1 - V

Thermoplastic elastomer type:
E = polyether ester; polyether = PTHF
P = polyether ester; polyether = PEO/PPO
U = polyester ester; (with extra urethane linkages)

Indication of viscosity range or processing technique
L, M = injection moulding and extrusion
B = blow moulding grade

Indication of hardness (Shore D)

Serial number

Indication of additives, perfomance
H = heat-stabilized
L = light/UV stabilized
V = flame-retardant (not V-0)
S = flame-retardant (V-0)

Figure 2.2: *Arnitel product coding*

2.3 Product portfolio

The Arnitel productrange is available with a hardness from 38 to 74 Shore D. The general Arnitel grades are shown in table 2.2. In order to enhance the flexibility of the portfolio a set of masterbatches (a.o. for heat, UV, etc) are on offer (refer to § 2.4).
Because of the development of these masterbatches heat stabilised Arnitel P is suggested for application areas where thermo-oxidative stability is an issue. For applications where colour and UV stability is required, the Arnitel E range is advised.

	Shore D					
	38	40	46	55	63	74
Arnitel E		EM400	EM460	EL550 EM550	EL630 EM630	EL740 EM740
Arnitel P	PL380		PL460	PL580 PM581		
Arnitel U				UM551 UM551-V UM552 UM552-V	UM622	

Table 2.2: *Arnitel productrange for general purpose*

Besides these multi-purpose grades, specialty grades can be offered for specific purposes and/or application areas. These grades are not intended for regular sales and are therefore restricted. Permission from marketing is needed before sampling is initiated.

	A'tel E	A'tel P	A'tel U
Automotive			
• CVJ boots	EB460 EB463 EB464		
• Boyplugs		PL380-M0	
Extrusion			
• Roofing foil	EM402-L		

Table 2.3: *Examples of specialty grades*

2.8.31 General:

Arnitel is the brand name of a series polyester based thermoplastic elastomers. These polymers combine excellent processability with good elastomeric properties between -40 and 200°C. Arnitel EL630 and EM630 are excellent materials for injection moulding and extrusion applications respectively.
The chemical stucture of Arnitel EL630/EM630 is shown below.

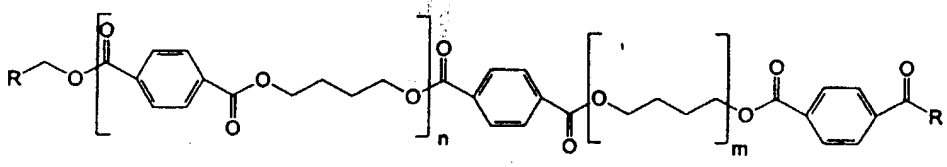


Figure 2.9: *Chemical structure of Arnitel EL630/EM630.*

Another way of writing the structure of Arnitels is shown below in Figure 2.

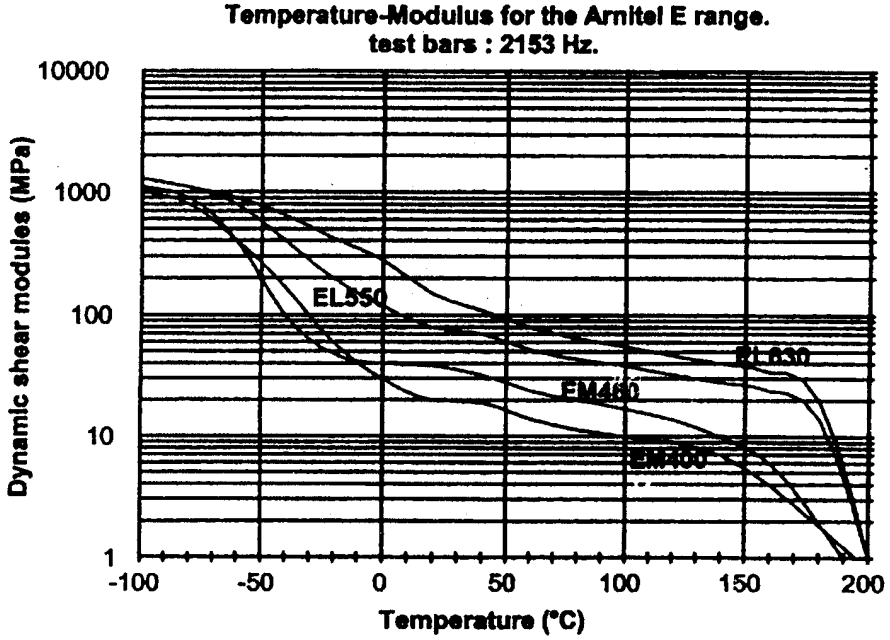
Figure 2.10: *Simplified structure of Arnitel EL630/EM630 .*

Arnitel EL630/EM630 is TOSCA registered (including DSL-Canada) under CAS 37282-12-5

2.8.32 Thermal properties:

- **Modulus-temperature behaviour:**

The materials have a glass transition at circa -40°C and a typical melting point at 213°C.
The modulus-temperature behaviour is shown in graph 2.76, for comparison, accompanied by other Arnitel E types.



Graph 2.76: *Modulus-temperature behaviour of Arnitel EL630/EM630.*

Although information on performance at higher temperatures may be extracted from the above shown graph, a Vicat or HDT are shown in table 2.29.

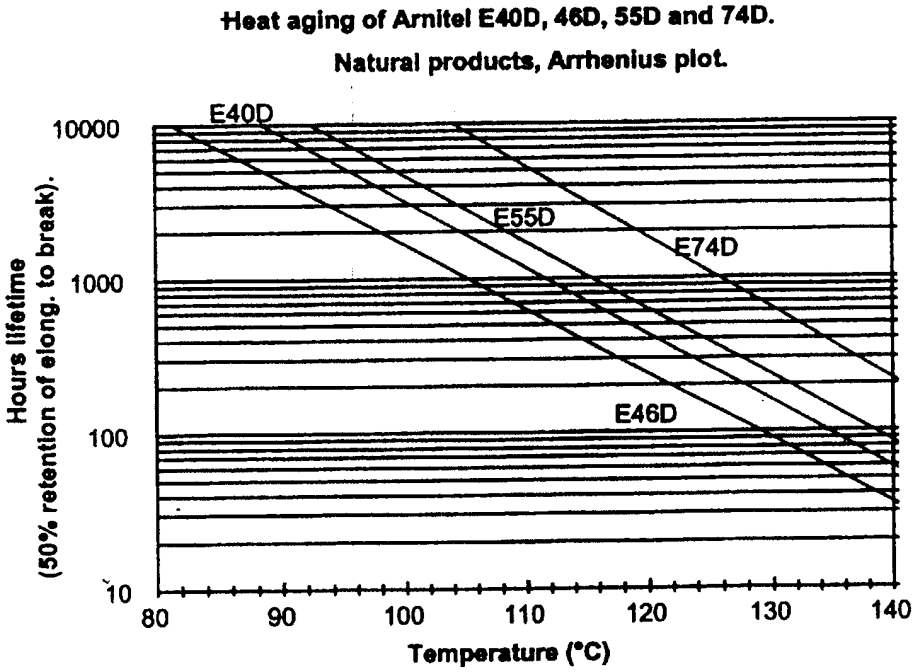
analysis	SI unit	typical data	test method
Vicat A	(°C)	200	ISO 306/A
Vicat B	(°C)	125	ISO 306/B
HDT-B	(°C)	115	ISO 75-1

Table 2.29: *Vicat and HDT data on Arnitel® EL630 and EM630*

Arnitel EL630 and EM630 have a melting point of 213°C as found in the second heating curve of a DSC. The polymer will crystallize at 155°C using a 20°C/min cooling rate.
The thermal expansion coefficient of Arnitel EL630/EM630 and is $140*10^{-4}$ µm/m.K .

- **Heat aging:**

Arnitel EL630/EM630 shows an optimum between heat resistance and colour stability. Heat aging for EL630/EM630 is under test at this moment, however the data will be between EL550 and EL740. Arrhenius curves of thermo-oxidative heat aging are shown in graph 2.77. Criterium chosen is retention of 50% original elongation at break.



Graph 2.77: *Heat stability for Arnitel E-range.*

Heat ageing can be improve using a stabilisation masterbatch, however for heat stabilisation the P-range is preferred for it's excellence in performance. These data can be found in the Arnitel properties summary or an Arnitel P datasheet.

2.8.33 Processing and Handling:

Arnitel EL630/EM630 is a polyester with a density of 1.12 g/cm^3 according ISO 1183.
Due to the polyester nature of these materials it is of major importance to store the material dry prior to processing. Materials packaged in sealed packaging should have a moisture content lower then 500 ppm. The polymer will contain 0.12% moisture in 50% RH and 0.58% water after saturation in water. Both numbers are in equilibrium.
If samples have become wet during storage a drying step of 24 hours 120°C (or 6 hours 140°C) prior to use will prevent degradation of the material during processing combined with an eventual loss of properties. The air or nitrogen will have to have a dew point of at least -30°C.

- **Processing:**

Arnitel EL630/EM630 shows a single melting point at 195°C in DSC. Processing conditions are shown in the table below.

polymer	zone 1	zone 2	zone 3	additional	melt	mold
EL630	225	230	235	235	225-235	20-50
EM630	225	230	235	235	235	50

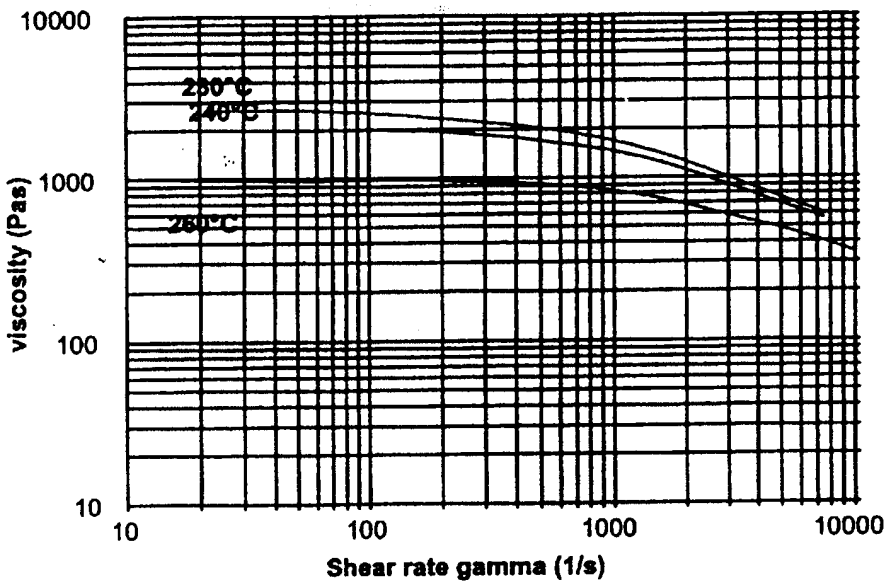
All temperatures are in °C.

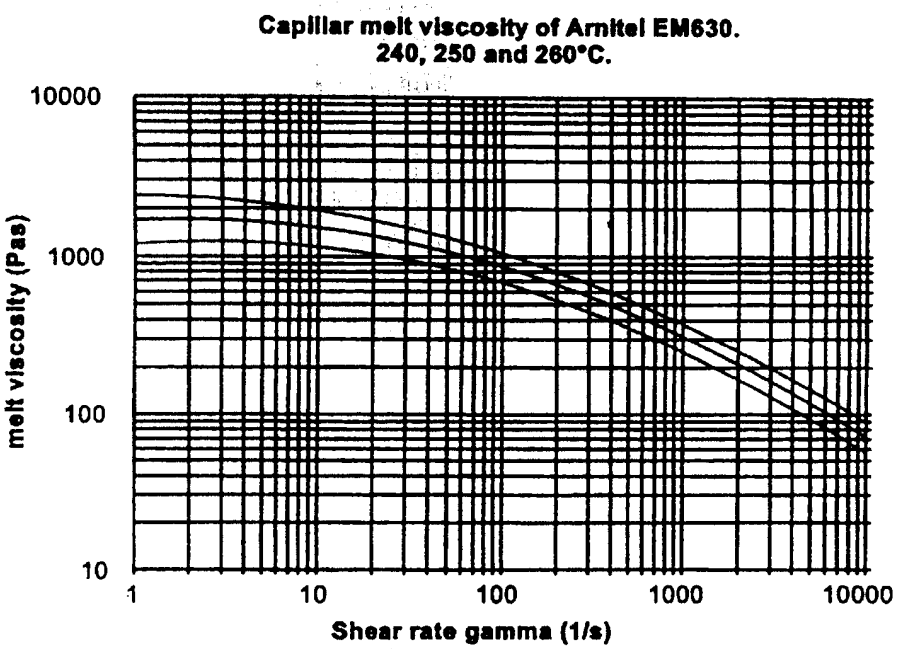
Table 2.30: *Processing conditions for Arnitel EL630 and Arnitel EM630.*

- **Rheology:**

The temperature depending melt viscosity of Arnitel EL630/EM630 and are shown below in graph 2.80 and 2.81 respectively.

Shear rate dependent of the melt viscosity of Arnitel EL630.
Effect of melt temperature.





Graph 2.80 and 2.81: *Temperature dependancy of the melt viscosity for Arnitel EL630 and EM630 .*

The MFI values are shown in table 2.31.

		EL630	EM630	
MFI 230°C	g/10 min		7	ISO 1133
MFI 240°C	g/10 min	30		ISO 1133

Table 2.31: *MFI for Arnitel EL630/EM630.*

- **Use of regrind:**

Arnitel can readily be recycled. If the MFI of the regrind is up or down to four points higher, 20% can be recycled. A difference of 2 MFI points allows up to 50% of regrind. Obviously the regrind should be dried properly before use.

2.8.34 Mechanical properties:

If Arnitel EL630 or Arnitel EM630 are processed properly the materials will have mechanical properties as shown in table 2.32.

Mechanical property	SI Unit	typica data*		test method
		EL630	EM630	
Hardness	Shore D	63	63	ISO 868
Tensile modulus (1 mm/min)	MPa	330	330	ISO 527
Tensile strength (50 mm/min)	MPa	30	30	ISO 527
Strain at break	%	350	350	ISO 527
Tensile stress at 5% strain	Mpa	11.5	11.5	
Tensile stress at 10% strain	Mpa	15.9	15.9	
Tensile stress at 50% strain	Mpa	17.3	17.3	
Tear strength Graves	KN/m	145	145	DIN53515
Izod notched 23°C (73°F)	KJ/m^2	NB	NB	ISO 180/1A
Izod notched -30°C (-22°F)	KJ/m^2	4	4	ISO 180/1A
Charpy notched 23°C (73°F)	KJ/m^2	NB	NB	ISO 179/1eA
Charpy notched -30°C (-22°F)	KJ/m^2	12	12	ISO 179/1eA

*1 Data for dry natural materials.
NB: No Break

Table 2.32: *mechanical properties of Arnitel® EL630.*

- **Abrasion:**

Arnitels show good abrasion resistance in both Taber and DIN 53516 abrasion tests. Data are shoen in the Arnitel general property overview (also included in the EPIC)

2.8.35 Flame retardancy:

Arnitel EL630 and EM630 show in an ISO1210/A flammability test a burning rate leading to a classification FH-1. Flame retardancy can be improved using a halogenated or halogen free FR masterbatch.

2.8.36 Electrical properties:

Arnitel EL630/EM630 can be used for cable jacketting applications. If the material is in permanent contact with copper a copper stabilisation package should be added. If the copper wires are coated with a tin layer, no stabilisation is necessary. The electrical properties are shown in table 33.

Electrical property	SI Unit	typica data*		test method
		EL630	EM630	
Dielectric strength	KV/mm	22	22	IEC 243-1
Relative permittivity (ε_r) at 1 kHz	-	4.4	4.4	IEC 250
Dissipation factor (tan δ) at 1kHz	-	0.019	0.019	IEC 250
Comparative tracking index	-	600	600	IEC 112
Volume resistivity	$10^{14}\Omega$.cm	1	1	IEC 93
Surface resistivity	$10^{14}\Omega$	1	1	IEC 93

Table 2.33: *Typical electrical properties of Arnitel® EL630 and EM630.*

2.8.37 Chemical resistance:

Arnitel EL630 and EM630 are sensitive to strong bases and strong acids, especially at elevated temperatures. In some halogenated hydrocarbons (like tetrachloroethane), the materials (partially) dissolves. For a full review on chemical resistance of Arnitel EL630 and EM630 request the chemical resistance brochure.

- **Hydrolysis**

Like all polyesters Arnitel are sensitive to moisture, however Arniteis are more stable to water then e.g. PET and PBT. graph 2.84 shows the hydrolytic stability of Arnitel EL630 at 100°C and in steam (120°C). For improved hydrolysis stability, using a polycarbodiimid containing masterbatch like Stabaxol® in an option. To maintain all other properties use a masterbatch based on polyester.Data on the Stabaxol stabilised grade are shown in graph 2.85.

■Panlite L-1250Z

Category	Unit	Test Method	Condition	L-1250Z 100
Melt volume flow rate	cm^3/10min	ISO 1133	300℃ load 1.2kg	8
Density	kg/m^3	ISO 1183	—	1200
Water absorption rate	%	ISO 62	in water 23℃24h	0.2
Light transmission	%	ASTM D 1003	thickness 3mm	88
Refractive index	—	ASTM D 542	—	1.585
Tensile modulus	MPa	ISO 527-1 and ISO 527-2	1mm/min	2400
Tensile stress at yield	MPa		50mm/min	61
Tensile strain at yield	%		50mm/min	6
Nominal tensile strain at break	%		50mm/min	>50
Flexural modulus	MPa	ISO 178	2mm/min	2350
Flexural strength	MPa		2mm/min	93
Charpy impact strength	KJ/m^2	ISO 179	unnotched	NB
			notched	76
Heat deflection temperature	℃	ISO 75-1 and ISO 75-2	1.80MPa	129
			0.45MPa	142
Vicat softening temperature	℃	ISO 306	50℃/h 50N	149
Mold shrinkage	%	In-house method	parallel	0.5～0.7
			vertical	0.5～0.7
Coefficient of linear expansion	$\times 10^{-4}$/℃	ISO 11359-2	parallel	0.7
			vertical	0.7
Specific inductive capacity	—	IEC 60250	100Hz	3.1
	—		1MHz	3
Dielectric loss tangent	$\times 10^{-4}$	IEC 60250	100Hz	10
	$\times 10^{-4}$		1MHz	90
Volume resistivity	Ω・m	IEC 60093	—	$>1 \times 10^{13}$
Surface resistivity	Ω	IEC 60093	—	$>1 \times 10^{15}$
Withstand voltage	MV/m	IEC 60243-1	short time test	30
Tracking resistance	—	IEC 60112	—	250
Flammability	—	UL 94	—	V-2(0.40mm) HB(1.5mm)
Temperature index	℃	UL 746B	electric 1.47mmt	125
			impact 1.47mmt	115
			non-impact 1.47mmt	125

※The values listed are specification values, not certified values.

Two-part adhesive		1590	High Super 5	EP-330 (HighSuper30)	EP-331	1500	Super
Feature		curing for 5 min type		curing for 30 min type	curing for 30min type Low-viscosity	Standard type	
Appearance	Base	Clear, blue	Translucent, blue	Translucent, pink	Clear, light yellow	Clear, light yellow	Translucent
	Hardener	Clear ight yellow	Translucent, light yellow	Translucent, milk white	Clear, light yellow	Clear, light brown	Light yellow
Viscosity (Pa·S/20℃)	Base	8	120	80	7	25	100
	Hardener	12	70	170	7	60	50
Specific gravity (g/cm^2)	Base	1.17	1.17	1.17	1.16	1.16	1.14
	Hardener	1.11	1.15	1.14	1.16	0.97	0.99
Mixing ratio(Base : Hardener)		1 : 1	1 : 1	1 : 1	1 : 1	1 : 1	1 : 1
Pot life		Within 5 min	Within 5 min	Within 30 min	Within 30 min	Within 1 hr	Within 1 hr
Tensile shear stength(N/mm^2)		19.0	18.0	17.5	17.6	15.7	15.1
T-Formed peeling adhesion (N/mm)		2.71	0.31	0.47		0.40	
Hardness(shore D)		77	77	82	71	82	
Coefficient of linear expansion ($\times 10^{-5}$)		8.6	10.7	6.7	4.1	7.1	
Tg(℃)			47	43		53.7	
Volume resistivity(Ω · cm)			4.9×10^{15}	3.8×10^{11}	3.6×10^{11}	1.1×10^{16}	
Coefficient of water absorption(%)			2.5	2.3		0.8	
Capacity standards		Base 1 kg Hardener 1 kg	6 g set 15 g set 25 g set 80 g set	320 ml set Base 3 kg Hardener 3 kg 6 g set, 15 g set, 80 g set	Base 1 kg Hardener 1 kg	Base 500 g, 1 kg, 3 kg, 15 kg Hardener 500 g, 1 kg, 3 kg, 15 kg	15 g set 40 g set 110 g set

施敏打硬
CEMEDINE
1500

〔一般性質〕

	主　　劑	硬　化　劑
主 要 成 分 顏 色 常 態	環氧（Epoxy）樹脂的中間體淺黃色透明液體	聚醯胺（Poly-Amido）樹脂棕色透明液體
不揮發率（%）	99.6	99.4
黏度(9/20°C)	350	600
比重(20/20°C)	1.16	0.97
溶　　劑	無	
硬化劑混合比例phr	60～110	
保持粘度時間	參照混合硬化劑後的粘度變化表	
膠 化 時 間	3 小時	
硬化所需時間	6 小時10分鐘	
可保存時間（20°C）	2 年	

〔特性〕

由兩種液體混合而成的環氧（ Epoxy ）樹脂系黏著劑，能在常溫下硬化，應用範圍至為廣汎，可穩定黏着金屬，塑膠以及其他各種物質。而由於此黏着劑，通常以聚醯胺（Poly-Amido）樹脂為其硬化劑，具有下列各優點：

1. 能在常溫下硬化。
2. 縱使所使用的硬化劑份量不同，也不影響其特性。
3. 由於能產生比一般黏着劑富有彎曲性的黏着層，縱使黏着不同材質的物品，也能以黏着層緩和熱膨脹的差別所引起的兩物品彎曲，對機械學的衝擊也能顯示較為良好的性能。
4. 由於能形成透明的黏着層，可以黏着透明的物質，如玻璃等等。

〔用　途〕

由於能強力黏着各種物質，諸如金屬，熱硬化塑膠，玻璃，飛機裝配以及一般家庭器具等等，應用範圍至為廣汎。

縱然是按聚乙烯（Polythylene），聚酯（ Polyester ），天然以及人造橡膠等，以一般的黏着根本無法黏着的物質，如果加以適當的表面處理，仍可強力黏着。

〔實　例〕

汽車、火車、船隻、飛機……。（將金屬把手黏着於玻璃窗／可以黏着鋁製品，三聚氰胺（Melamine）裝飾板等，於內部以增加強度／不同金屬間爲防止電偶且加黏之／當作防腐塗料亦可）。

電器製品……。（由於是一種優秀的黏着劑，使用於高級擴聲器、音響線圈的黏着／電磁器或外殼的黏着／線圈框的黏着／鐵芯部的黏着／馬達線圈的黏着等等）。

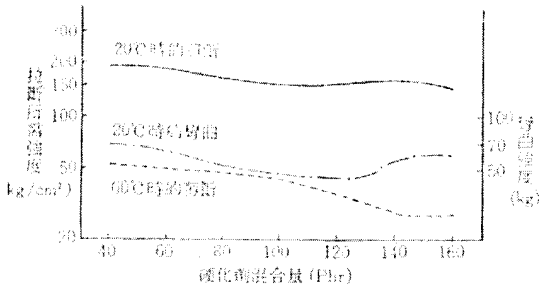
建築……（玻璃、壓克力可使將文字板貼於牆壁貼住把手，照明設備以及其他塑膠裝飾品的加黏以及組立／不銹鋼製品、鋁製鋁材、陶器或大理石等需要強力黏劑的物品的加黏）。

高級裝飾品，玻璃以及塑膠製工藝品，精密機械……（照像機，調整距離筒／分光儀等等的固定）。

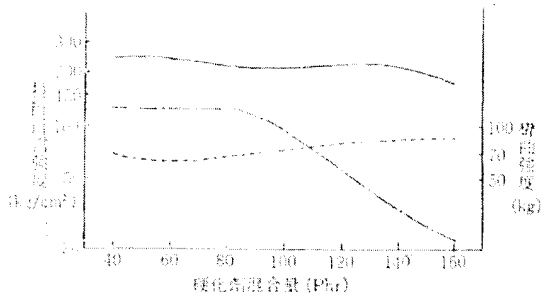
其他諸如鏡頭，運動器材，公路標誌等等的加黏。

除上述各種加黏外，也可以使用作填充劑，該機用，家庭用以及試驗用。

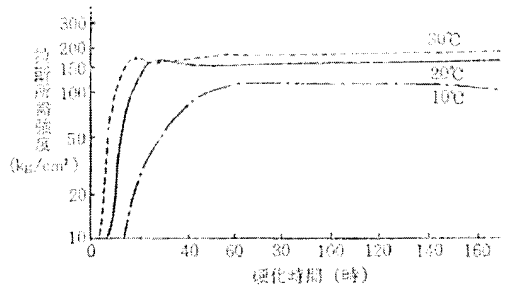
[illegible]	[illegible]
50	150 [illegible]
80	60 [illegible]
100	40 [illegible]
[illegible]	30 [illegible]



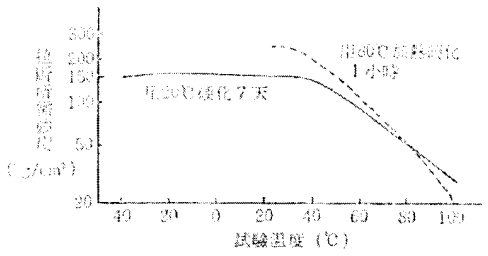
圖Ⅱ 2.1
硬化劑混合量和拉力強度
（在20℃七天的硬化）
試驗片：鐵板 (25×100×1.6mm)
(Over-lap)12.5mm



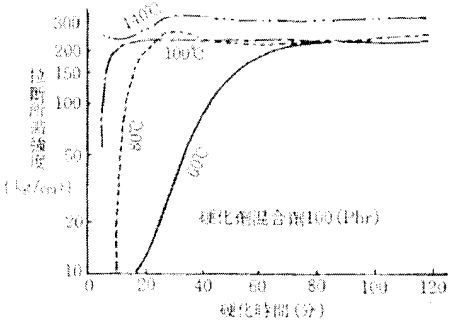
圖Ⅱ 2.2
硬化劑混合量和拉力強度
（在80℃一小時後硬化）
試驗片：同及其他同圖Ⅱ 2.1



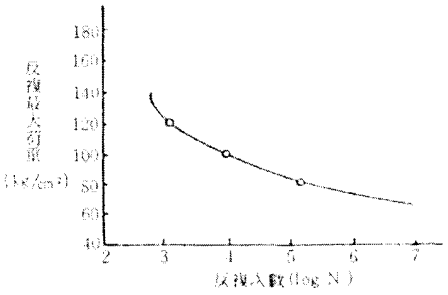
圖Ⅱ 2.3
常溫時的硬化特性 硬化劑混合率 100phr



圖Ⅱ 2.5
耐熱特性 硬化劑混合率為 100phr



圖Ⅱ 2.4
加熱硬化特性 硬化劑混合率為 100phr



圖Ⅱ 2.6
老化特性

表Ⅱ 2.1 物理特性

抗 張 力 (kg/mm²)	5.04	硬度 ロックウェルM	68
抗 折 力 (kg/mm²)	7.40	硬度 バーコル	67
彎曲彈性率 (kg/mm²)	214	硬度 ショアー D	82
剪斷強度 (kg/mm²)	11.6	表面固有電阻 (Ω)	5.6×10^{13}
壓縮強度 (kg/mm²)	15.10(6.11)(1)	體積固有電阻 (Ω-Cm)	10.5×10^{13}
熱變形溫度 (℃)	47	誘電率 (10^6cycle)	2.91
		絕緣破壞 (kv/mm)	19

表Ⅱ 2.2 拉斷所需強度

被接著物	拉斷所需強度	被接著物	拉斷所需強度 (20°C)
樺樹材	83	多元乙烯皮	22
馬來西亞杉材	106 ＊	苯乙烯樹脂	19
柳安樹材	99＊	壓克力樹脂	30
杉材	66	硬質氯乙烯樹脂	36
鐵	158	三聚氰胺裝飾板（表面）	55
鋁	61	三聚氰胺裝飾板（背面）	45
黃銅	60	F R P	125
銅	80		
強化玻璃	71		
普通玻璃	50		

〔註〕 1. 粘著條件： 20°C，硬化7天，硬化劑混合比 100phr(接合部over-lap)12.5mm。

2.＊記號者表示材料拉斷。

表Ⅱ 2.3 促進劣化特性

試驗	未試驗前的粘力強度 (kg/cm²)	比較調整試驗片的粘力強度(1)（1個月） (kg/cm²)	經過各試驗1個月後的粘力強度 (kg/cm²)	經過各試驗 1,000 小時後的粘力強度 (kg/cm²)
利用測候儀所做的耐候試驗	143	150	—	166
利用噴射鹽水的促進試驗	143	150	100	—
利用高溫高濕的促進試驗(2)	143	150	143	—
利用反復冷却的促進試驗(3)	143	150	183	—

〔註〕(1) 20±1°C, 65±5%RH 各保持1個月的試驗片；(2)50°C100%RH；(3)−5°C8小時～50°C16小時。

表Ⅱ 2.4 耐候性

拉斷所需強度 (kg/cm²)

暴露前的粘力強度					147
比較調整試驗片的粘力強度（6個月）	※	156	在戶外暴露6個月的粘力強度		147
〃（1年）	※	138	〃 1年	〃	152
〃（2年）	※	130	〃 2年	〃	138
〃（3年）	※	123	〃 3年	〃	137
〃（10年）	※	111	〃 10年	〃	130

〔註〕※20±1°C, 65±5%RH 保持各期間的試驗片。

表Ⅱ 2.5 耐水性 (20°C,7天硬化)

拉斷所需強度 (kg/cm²)

試驗＼時間	0	3個月	6個月	1年
常態試驗	120	106	123	120
耐水試驗		109	117	109

〔註〕硬化劑混合比為 100phr
試驗片：不銹鋼 (100×25×1.5mm)
(接合部Over-lap)12.5mm。

表Ⅱ 2.6 耐水性 (60°C, 2小時硬化)

拉斷所需強度 (kg/cm²)

試驗＼時間	0	3個月	6個月	1年
常態試驗	157	150	169	163
耐水試驗		133	108	116

〔註〕同表Ⅱ 2.5

表II 2.7 耐油性

拉剪斷強度 (kg/cm²)

放置日數	1天	3天	5天	10天	20天	1個月
放置於20°C室溫	—	—	—	80.0	—	79.0
0°C油中	—	—	77.5	87.5	—	80.0
20°C油中	—	—	82.5	77.6	—	89.5
70°C油中	77.6	75.3	80.0	74.3	—	71.0
循環油中 cycle	—	—	79.0	78.0	89.0	76.0

放置日數	40天	2個月	3個月	6個月	1年	10年
放置於20°C室溫	—	—	73.0	65.9	76.3	15.4
0°C油中	—	86.5	71.5	80.5	80.2	—
20°C油中	—	70.5	79.5	78.7	79.7	—
70°C油中	—	75.5	—	75.4	68.3	—
循環油中 (cycle)	71.5	—	—	—	—	—

〔註〕1. 硬化劑混合比為80phr，試驗片爲木片 (100×25×3mm) 接合部(Over-lap)12.5mm 2. 油為礦物油。
3. 試驗片全部破裂。

表II 2.8 耐溶劑、耐藥品性

種類		浸漬7天後的黏力保持率 (%)		浸漬1個月後的黏力保持率 (%)	
		以20°C硬化7天的試驗片	以80°C硬化1小時的試驗片	以20°C硬化7天的試驗片	以80°C硬化1小時的試驗片
溶劑	己烷	107.0	80.6	91.1	78.8
		85.5	63.8	51.7	66.8
		88.8	69.5	93.4	70.8
		89.5	71.3	97.4	68.7
		90.2	64.7	101.3	69.1
	三氯化烯	91.5	72.7	65.0	69.5
油	植物油	102.7	90.8	107.3	90.3
	礦物油	96.2	87.8	98.1	81.2
藥品	蒸餾水	93.4	72.3	96.3	69.3
	10%硫酸溶液	93.4	72.8	79.8	69.8
	10%鹽酸溶液	74.7	67.8	70.8	57.2
	10%苛性蘇打溶液	97.2	74.3	83.8	74.3
	10%食鹽水溶液	89.6	71.8	91.0	69.8
	10%醋酸溶液	94.2	77.8	78.1	64.2

〔註〕黏劑混合率＝1：1，試驗片：軟鋼片 (25×100×1.6mm) 但是耐水試驗時使用了SUS-27，接合部 (Over-lap) 為 12.5mm。

容量規格—(主)、(硬) 110g、1kg、 15kg (組)

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