

Technical Datasheet

DESCRIPTION

Novodur® H604 is a high heat injection molding grade with enhanced chemical resistance, especially suitable for being painted.

FEATURES

- High chemical resistance
- High heat resistance
- Premium paintable

APPLICATIONS

- Mirror housings
- Automotive interior trims
- Automotive interior decorations

Property, Test Condition	Standard	Unit	Values
Rheological Properties			
Melt Volume Rate 220 °C/10 kg	ISO 1133	cm ³ /10 min	8
Mechanical Properties			
Izod Notched Impact Strength, 23 °C	ISO 180/A	kJ/m ²	21
Izod Notched Impact Strength, -30 °C	ISO 180/A	kJ/m ²	12
Charpy Notched Impact Strength, 23° C	ISO 179	kJ/m ²	20
Charpy Notched Impact Strength, -30° C	ISO 179	kJ/m ²	11
Charpy Unnotched, 23° C	ISO 179	kJ/m ²	180
Charpy Unnotched, -30° C	ISO 179	kJ/m ²	110
Tensile Stress at Yield, 23° C	ISO 527	MPa	45
Tensile Strain at Yield, 23° C	ISO 527	%	2.6
Tensile Strain at Break, 23° C	ISO 527	%	> 15
Tensile Modulus	ISO 527	MPa	2400
Flexural Strength	ISO 178	MPa	70
Flexural Modulus	ISO 178	MPa	2400
Hardness, Ball Indentation	ISO 2039-1	MPa	105
Thermal Properties			
Vicat Softening Temperature VST/B/50 (50°C/h, 50N)	ISO 306	°C	102
Heat Deflection Temperature A; (annealed, 1.8 MPa)	ISO 75	°C	98
Heat Deflection Temperature B; (annealed, 0.45 MPa)	ISO 75	°C	102

Property, Test Condition	Standard	Unit	Values
Coefficient of Linear Thermal Expansion	ISO 11359	10 ⁻⁶ /°C	80
Electrical Properties			
Dissipation Factor (100 Hz)	IEC 60250	10 ⁻⁴	50
Dissipation Factor (1 MHz)	IEC 60250	10 ⁻⁴	90
Dielectric Strength, Short Time, 1.5 mm	IEC 60243-1	kV/mm	31
Relative Permittivity (100 Hz)	IEC 60250	-	3
Relative Permittivity (1 MHz)	IEC 60250	-	2.9
Volume Resistivity	IEC 60093	Ohm*m	>1E13
Surface Resistivity	IEC 60093	Ohm	>1E15
Comparative Tracking Index	IEC 60112	V	600
Other Properties			
Density	ISO 1183	kg/m ³	1040
Processing			
Linear Mold Shrinkage	ISO 294-4	%	0.5 - 0.7
Melt Temperature Range	ISO 294	°C	230 - 260
Mold Temperature Range	ISO 294	°C	60 - 80
Injection Velocity	ISO 294	mm/s	240
Drying Temperature		°C	80
Drying Time		h	2 - 4

Typical values for uncolored products

SUPPLY FORM

Novodur® is delivered in the form of cylindrical or spherical pellets. The bulk density of the pellets is from 0.55 to 0.65 g/cm³. Values may differ for special grades. Standard Packaging unit: 25 kg PE-bag on palette, shrunk or wrapped with PE film. In addition, delivery in larger units of up to 1000 kg (IBC = Intermediate Bulk Container) or silo trucks can be arranged. In dry areas with normal temperature control, Novodur pellets can be stored for relatively long periods of time without any change in mechanical properties. With unstable colors, however, storage over a number of years can give rise to some change in color. Under poor storage conditions, Novodur absorbs moisture, but this can be removed by drying.

PRODUCT SAFETY

No adverse effects on the health of processing personnel have been observed where the products are correctly processed and the production areas are suitably ventilated. For styrene, alpha-methylstyrene, acrylonitrile, and butyl acrylate the maximum allowable workplace concentrations must be observed according to the pertaining national regulations. In Germany, the following limit values are valid TRGS 900 (Aug. 2004): styrene, MAK-value: 20 ml/m³; alpha-methylstyrene, MAK-value: 100 ml/m³; acrylonitrile, TRK-value: 3 ml/m³, and butyl acrylate, MAK-value: 2 ml/m³ (1.7.2004). According to EU directive 67/548/EEC, Annex I (2001), acrylonitrile is classified as carcinogenic, category 2 ('substances which should be regarded as if they are carcinogenic to man'). Experience has shown that when Novodur® is processed correctly with appropriate ventilation, the levels are far below the limits mentioned above. Inhalation of the vapors of degradation products which can arise on severe overheating of the materials or during purging out should be avoided. Further information can be found in the Novodur safety data sheets.

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