

Novodur® H604

Acrylonitrile Butadiene Styrene

Styrolution

Message:

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

General Information			
UL YellowCard	E256400-538835		
Features	Good Chemical Resistance		
	High Heat Resistance		
	Paintable		
Uses	Automotive Applications		
	Automotive Interior Trim		
	Housings		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage	0.50 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	105	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	45.0	MPa	ISO 527-2
Tensile Strain			ISO 527-2
Yield, 23°C	2.6	%	
Break, 23°C	> 15	%	
Flexural Modulus	2400	MPa	ISO 178
Flexural Stress	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	11	kJ/m ²	
23°C	20	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	110	kJ/m ²	
23°C	180	kJ/m ²	

Notched Izod Impact Strength			ISO 180/A
-30°C	12	kJ/m ²	
23°C	21	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Annealed	102	°C	ISO 75-2/B
1.8 MPa, Annealed	98.0	°C	ISO 75-2/A
Vicat Softening Temperature	102	°C	ISO 306/B50
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength ¹ (1.50 mm)	31	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.00		
1 MHz	2.90		
Dissipation Factor			IEC 60250
100 Hz	5.0E-3		
1 MHz	9.0E-3		
Comparative Tracking Index	600	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	220 to 260	°C	
Mold Temperature	70.0	°C	
Injection Velocity	240	mm/sec	
NOTE			
1.	Short Time		

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