

## DESCRIPTION

Novodur® Ultra 4140PG is a PC modified plating grade combining high heat resistance and excellent impact strength with the unique surface properties of a Novodur® ABS material.

## FEATURES

- Electroplating grade
- Very high impact strength
- High heat resistance

## APPLICATIONS

- Auto front plated grill parts
- Auto interior high heat electroplating applications

Property, Test Condition	Standard	Unit	Values
<b>Rheological Properties</b>			
Melt Volume Rate 220 °C/10 kg	ISO 1133	cm <sup>3</sup> /10 min	9
Melt Volume Rate, 260 °C/5 kg	ISO 1133	cm <sup>3</sup> /10 min	13
<b>Mechanical Properties</b>			
Izod Notched Impact Strength, 23 °C	ISO 180/A	kJ/m <sup>2</sup>	40
Izod Notched Impact Strength, -30 °C	ISO 180/A	kJ/m <sup>2</sup>	31
Charpy Notched Impact Strength, 23° C	ISO 179	kJ/m <sup>2</sup>	38
Charpy Notched Impact Strength, -30° C	ISO 179	kJ/m <sup>2</sup>	28
Tensile Stress at Yield, 23° C	ISO 527	MPa	46
Tensile Strain at Yield, 23° C	ISO 527	%	3.5
Tensile Strain at Break, 23° C	ISO 527	%	> 15
Tensile Modulus	ISO 527	MPa	2100
Flexural Strength	ISO 178	MPa	72
Flexural Modulus	ISO 178	MPa	2100
Hardness, Ball Indentation	ISO 2039-1	MPa	85
<b>Thermal Properties</b>			
Vicat Softening Temperature VST/B/50 (50N, 50°C/h)	ISO 306	°C	106
Heat Deflection Temperature A; (annealed 4 h/80 °C; 1.8 MPa)	ISO 75	°C	99

# Novodur Ultra 4140PG

Acrylonitrile Butadiene Styrene / Polycarbonate (ABS/PC)

## TECHNICAL DATASHEET

Property, Test Condition	Standard	Unit	Values
Heat Deflection Temperature B; (annealed 4 h/80 °C; 0.45 MPa)	ISO 75	°C	108
Coefficient of Linear Thermal Expansion	ISO 11359	10 <sup>-6</sup> /°C	90
<b>Electrical Properties</b>			
Dissipation Factor (100 Hz)	IEC 60250	10 <sup>-4</sup>	40
Dissipation Factor (1 MHz)	IEC 60250	10 <sup>-4</sup>	85
Dielectric Strength, Short Time, 1.5 mm	IEC 60243-1	kV/mm	37
Relative Permittivity (100 Hz)	IEC 60250	-	3
Relative Permittivity (1 MHz)	IEC 60250	-	3
Volume Resistivity	IEC 60093	Ohm*m	>1E13
Surface Resistivity	IEC 60093	Ohm	>1E15
Comparative Tracking Index	IEC 60112	V	600
<b>Other Properties</b>			
Density	ISO 1183	kg/m <sup>3</sup>	1070
<b>Processing</b>			
Linear Mold Shrinkage	ISO 294-4	%	0.6 - 0.8
Melt Temperature Range	ISO 294	°C	240 - 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/cm<sup>3</sup>. 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/m<sup>3</sup>; alpha-methylstyrene, MAK-value: 100 ml/m<sup>3</sup>; acrylonitrile, TRK-value: 3 ml/m<sup>3</sup>, and butyl acrylate, MAK-value: 2 ml/m<sup>3</sup> (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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