

Novodur® ECO H605 MR30

ABS

INEOS Styrolution

Novodur® ECO H605 MR30 is a high heat injection molding grade with enhanced flowability and low emission, i.e. suitable to produce parts which fulfill interior emission requirements of the automotive OEMs. The product contains 30% post-consumer mechanically recycled ABS and has received RecyClass certification.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm³/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2700	MPa	ISO 527
Yield stress	46	MPa	ISO 527
Yield strain	2.4	%	ISO 527
Nominal strain at break	14	%	ISO 527
Impact Strength (Charpy), +23°C	60	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	50	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	13	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	7	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	2600	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Ball Indentation Hardness	116	MPa	ISO 2039-1

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	99	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	102	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	102	°C	ISO 306

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	1.03	%	Sim. to ISO 62
Density	1050	kg/m³	ISO 1183
Bulk density	600	kg/m³	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	230 - 260	°C	-
Mold temperature	60 - 80	°C	-

Characteristics
Processing

Injection Molding

Features

High Gloss, Low Emission

Delivery form

Pellets

Certifications

Recycled Resin Content

Special Characteristics

Heat aging stabilized

Applications

Automotive, Electrical and Electronical

Injection Molding
PREPROCESSING

Pre-drying, Temperature: 80°C

Pre-drying, Time: 2 - 4h

PROCESSING

Melt temperature, range: 230 - 260°C

Mold temperature, range: 60 - 80°C