
ELIX ULTRA HH 4115 PG

Very high heat resistance ABS plating grade

ISO shortname: ISO 2580-1 ABS 2-X, MG, 115-15-35-20

Major Benefits

- . Extreme impact resistance with low temperature ductility
- . Very high impact up to -30°C
- . Well balanced flowability, heat resistance and flexibility
- . Low emission and odor grade
- . Lower mould deposits in injection molding processing applications
- . Good dimensional precision, low shrinkage and CLTE.
- . Lower density than PC/ABS

Chemical composition

Acrylonitrile-butadiene-styrene (ABS) copolymer modified with polycarbonate and poly(styrene-co-maleimide)

Physical form

White to slightly yellowish pellets.

Handling information

Please see the Material Safety Data Sheet for relevant health & safety information.

Typical properties¹

Property	Test Condition	Unit	Standard	Value
Rheological properties				
Melt volume-flow rate	260°C, 5Kg	cm ³ /10 min	ISO 1133	14
Molding shrinkage, parallel	60x60x2 mm	%	ISO 294-4	0.65-0.75
Molding shrinkage, normal	60x60x2 mm	%	ISO 294-4	0.65-0.75
Mechanical properties (23°C /50% H.R.)				
Yield stress	50 mm/min	MPa	ISO 527-1,2	42
Yield strain	50 mm/min	%	ISO 527-1,2	7
Elongation at break	50 mm/min	%	ISO 527-1,2	53
Tensile modulus	1 mm/min	MPa	ISO 527-1,2	2000
Flexural modulus	2 mm/min	MPa	ISO 178	2000
Flexural strength	2 mm/min	MPa	ISO 178	68
Izod notched impact strength	23 °C	KJ/m ²	ISO 180-1A	58
Izod notched impact strength	-30 °C	KJ/m ²	ISO 180-1A	41
Charpy notched impact strength	23 °C	KJ/m ²	ISO 179-1eA	53
Charpy notched impact strength	-30 °C	KJ/m ²	ISO 179-1eA	40
Ball indentation hardness		N/mm ²	ISO 2039-1	90
Thermal properties				
Vicat softening temperature	B50, 50°C/h	°C	ISO 306	113
Vicat softening temperature	B120, 120°C/h	°C	ISO 306	115
Deflection temperature under load	1.80 MPa	°C	ISO 75-1,2	101
Deflection temperature under load	0.45	°C	ISO 75-1,2	113
CLTE, parallel	23 to 55°C	10 ⁻⁴ /K	ISO 11359 -1,2	0.89
Burning behavior UL 94	1.6 mm	Class	UL 94	HB
Burning rate (US-FMVSS)	150x110x2mm	mm/min	ISO 3795	< 40
Other properties (23°C)				
Density	25°C	Kg/m ³	ISO 1183-1	1.07
Processing conditions for test specimens				
Injection molding-melt temperature	240	°C	ISO 294	
Injection molding-mold temperature	70	°C	ISO 294	
Injection molding-injection velocity	240	mm/s	ISO 294	

Notes : 1.control measurements in other places may issue different results due to influences of machinery, equipment, test method or storage conditions.

Disclaimer for sales products

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Test values

Unless specified to the contrary, the values given have been established on standardised test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the colouring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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