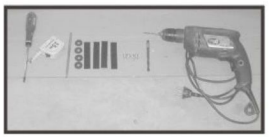
MOTORDROME DESIGN

TÜV THÜRINGEN

FRONT SPLITTER

Tools Needed

	Clean cloth Alcohol	Drill machine Drill ø4,2 mm Screwdriver

Placement instructions (For this job needed 2 people)

	Before starting the placement trying to match the spoiler on the car to find the right basement. Clean the car surface with cleaner.
	Carefully place the spoiler on the car and then attach the screws to their contact points. Always make holes on the spoiler and not on the bumper. Start screwing the bolts, holding the spoiler on the right place.
	The vehicle is ready to be used.

ATTENTION: On car use after the installation

For any queries or problem, you may encounter please contact us at Tel (0030) 210-5596682-3 or info@motordromedesign.com

PAINT AND PLACEMENT INSTRUCTIONS

MOTORDROME DESIGN

PAINTING INSTRUCTIONS

MATERIAL SPECIFICATION

LANXESS Energizing Chemistry

Lustran ABS E401

Extrusion grades / General purpose grades
ISO Shortname

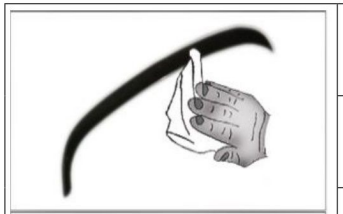
Extrusion grade, very high impact resistance, high gloss surfaces
ISO 2580-ABS 1,EG,095-04-35-20

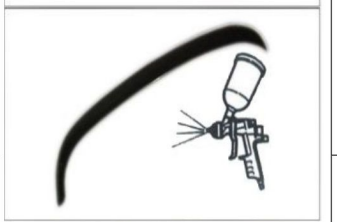
	Property	Test condition	Unit	Standard	Value
Pherological properties					
C	Melt volume-flow rate	220° C, 10 Kg	cm³/(10min)	ISO 1133	0.5 – 0.8
C	Molding shrinkage, parallel	60X60X2	%	ISO 294-4	0.5 – 0.8
C	Molding shinkrage, normal	60X60X2	%	ISO 294-4	
Mechanical properties (23° C/50 %r.h.)					
C	Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	1900
C	Yield stress	50 mm/min	MPa	ISO 527-1,-2	40
C	Yield strain	50 mm/min	%	ISO 527-1,-2	2.5
	Strain at break	50 mm/min	%	Acc. ISO 527-1,-2	> 15
C	Charpy impact strength	23° C	kJ/m²	ISO 179-1eU	210
C	Charpy impact strength	-30° C	kJ/m²	ISO 179-1eU	170
C	Charpy notched impact strength	23° C	kJ/m²	ISO 179-1eA	30
C	Charpy notched impact strength	-30° C	kJ/m²	ISO 179-1eA	16
	Izod notched impact strength	23° C	kJ/m²	ISO 180-1A	30
	Izod notched impact strength	-30° C	kJ/m²	ISO 180-1A	19
	Flexular modulus	2 mm/min	MPa	ISO 178	1900
	Flexular strength	2 mm/min	MPa	ISO 178	60
	Ball indentation hardness		N/mm	ISO 2039-1	85
Thermal properties					
C	Temperature of deflection under load	1.80 MPa	° C	ISO 75-1,-2	94
C	Temperature of deflection under load	0.45 MPa	° C	ISO 75-1,-2	100
C	Vicat softening temperature	50 N; 50° C/h	° C	ISO 306	99
C	Coefficient of linear thermal expansion, parallel	23 to 55° C	10-4/K	ISO 11359-1,-2	0.9
C	Burning behaviour UL 94 (1.6 mm)	1.6 mm	Class	UL 94	HB
	Burning rate (US-FMVSS)	2.0 mm	mm/min	ISO 3795	55
	Glow wire test (GWFI)	2.0 mm	° C	IEC 60695-2-12	700

EDITION 16.09.2004

Lustran ABS/ Novodur®
ISO datasheet

PROCESS FOR PAINTING





STAGE 1: STOCK
Stucco with soft putty any small graze or spots

STAGE 2: RUBBING
Rubbing all plastic surface with sandpaper 500 dry friction

STAGE 3: PRIMER PREPARATION
Give a good clean and paint with plast-flex depending on the color company you co operate. (Communicate with your supplier about the painting process for ABS plastic parts))

STAGE 4: FINAL PAINTING
Give a final good clean and paint with finishing acrylic paint

ATTENTION

(PAINTING TEMPERATURE SHOULD NOT EXCEED 40° C)