

Sindustris ABS LMA321

Acrylonitrile Butadiene Styrene

Sincerity Australia Pty Ltd.

Message:

Sindustris ABS LMA321 is an Acrylonitrile Butadiene Styrene (ABS) material. It is available in Asia Pacific for extrusion.

Important attributes of Sindustris ABS LMA321 are:

Flame Rated

Low Gloss

Typical applications include:

Automotive

Sheet

Trays/Racks

General Information			
Features	General Purpose		
	Low Gloss		
Uses	Automotive Applications		
	Sheet		
	Support Trays		
UL File Number	E306922		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.19	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	47.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 60	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	70.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	59	J/m	
-30°C, 6.40 mm	69	J/m	
23°C, 3.20 mm	98	J/m	
23°C, 6.40 mm	69	J/m	
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	91.0	°C	ASTM D648
Vicat Softening Temperature	99.0	°C	ASTM D1525 ⁵
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.800 mm	HB		
1.60 mm	HB		
2.50 mm	HB		
3.20 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.010	%	
Nozzle Temperature	200 to 230	°C	
Processing (Melt) Temp	200 to 230	°C	
Mold Temperature	40.0 to 60.0	°C	
Back Pressure	29.4 to 58.8	MPa	
Screw Speed	30 to 60	rpm	
Extrusion	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.010	%	
Melt Temperature	200 to 230	°C	
Die Temperature	200 to 230	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	15 mm/min		
5.	Rate A (50°C/h), Loading 2 (50 N)		

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