

Lustran® ABS 348

Acrylonitrile Butadiene Styrene
Styrolution

Message:

Lustran® ABS 348 resin is an injection molding grade of ABS (Acrylonitrile butadiene styrene). It is a medium impact, high-gloss ABS, available in natural (000000), snowwhite (012002), and selected colors.

Lustran ABS 348 resin combines a good balance of physical properties, intermediate abuse resistance, and rigidity. Typical applications include components of intravenous (IV) systems, diagnostic test kits, and surgical instruments. As with any product, use of Lustran ABS 348 resin in a given application must be tested (including but not limited to field testing) in advance by the user to determine suitability.

General Information			
UL YellowCard	E44741-235631		
Features	Rigidity, high		
	Highlight		
	Medium impact resistance		
Uses	Surgical instruments		
	Medical/nursing supplies		
Agency Ratings	EC 1907/2006 (REACH)		
	ISO 10993-Part I		
Appearance	White		
	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Multi-Point Data	Specific Volume vs Temperature (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Specific Volume	0.940	cm ³ /g	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	14	g/10 min	ASTM D1238
230°C/3.8 kg	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2620	MPa	ASTM D638
Tensile Strength (Yield)	48.3	MPa	ASTM D638

Flexural Modulus	2690	MPa	ASTM D790
Flexural Strength (Yield)	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	48	J/m	ASTM D256
23°C, 3.18 mm	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 12.7mm	92.8	°C	ASTM D648
0.45 MPa, annealed, 12.7mm	100	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	85.6	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	95.6	°C	ASTM D648
Vicat Softening Temperature	107	°C	ASTM D1525 ¹
CLTE - Flow	8.1E-5	cm/cm/°C	ASTM D696
RTI Elec (1.50 mm)	80.0	°C	UL 746
RTI Imp (1.50 mm)	80.0	°C	UL 746
RTI (1.50 mm)	80.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature			
A	82.2 - 87.8	°C	
B	71.1 - 76.7	°C	
Drying Time			
A	2.0	hr	
B	4.0	hr	
Suggested Max Moisture	< 0.10	%	
Suggested Shot Size	50 - 75	%	
Rear Temperature	235 - 249	°C	
Middle Temperature	241 - 254	°C	
Front Temperature	246 - 260	°C	
Nozzle Temperature	246 - 260	°C	
Processing (Melt) Temp	246 - 274	°C	
Mold Temperature	43.3 - 65.6	°C	
Injection Pressure	68.9 - 110	MPa	
Injection Rate	Fast		
Back Pressure	0.00 - 0.172	MPa	
Clamp Tonnage	2.8 - 5.5	kN/cm ²	
Cushion	< 6.35	mm	
Screw L/D Ratio	20.0:1.0		

Screw Compression Ratio	2.5:1.0
Injection instructions	
No regrind allowed for medical applicationsHold Pressure: 50 to 75% of Injection PressureScrew Speed: Moderate	
NOTE	
1.	标准 B (120°C/h)

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