Lustran® ABS 248

Acrylonitrile Butadiene Styrene

Styrolution

Message:

Lustran® ABS 248 resin is a high-gloss, medium-impact grade of ABS (Acrylonitrile Butadiene Styrene). This general-purpose injection molding grade offers a good balance of physical properties. It also complies with FDA regulation 21 CFR 181.32 for repeated-use food contact applications in certain colors. The resin is available in natural, black and custom colors.
Lustran ABS 248 is used in applications requiring rigidity and intermediate abuse resistance. Typical applications include housings for small appliances and toys. As with any product, use of Lustran ABS 248 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 Compliance of Food Exposure General Medium impact resistance
Uses	Large household appliances and small household appliances Electrical appliances General Shell Toys
Agency Ratings	EC 1907/2006 (REACH) FDA 21 CFR 181.32
Appearance	Black Available colors Natural color
Forms	Particle
Processing Method	Injection molding
Multi-Point Data	Isochronous Stress vs. Strain (ISO 11403-1) Isothermal Stress vs. Strain (ISO 11403-1) Secant Modulus vs. Strain (ISO 11403-1)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm³	ASTM D792
Specific Volume	0.940	cm³/g	
Melt Mass-Flow Rate (MFR)			ASTM D1238

220°C/10.0 kg	13	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)	46.9	MPa	ASTM D638
Flexural Modulus	2690	MPa	ASTM D790
Flexural Strength (Yield)	73.8	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	220	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 12.7mm	93.3	°C	ASTM D648
0.45 MPa, annealed, 12.7mm	100	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	86.1	°C	ASTM D648
1.8 MPa, annealed, 12.7mm [1]	102	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	95.6	°C	ASTM D648
Vicat Softening Temperature	107	°C	ASTM D1525 [2]
CLTE - Flow	8.1E-5	cm/cm/°C	ASTM D696
RTI Elec (1.47 mm)	80.0	°C	UL 746
RTI Imp (1.47 mm)	80.0	°C	UL 746
RTI (1.47 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
5.99 mm	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature - Desiccant Dryer	71.1 - 87.8	°C	
Drying Time - Desiccant Dryer	2.0 - 4.0	hr	
Dew Point - Desiccant Dryer	-28.9	°C	
Suggested Max Moisture	< 0.10	%	
Suggested Shot Size	50 - 75	%	
Suggested Max Regrind	20	%	
Rear Temperature	235 - 249	°C	
Middle Temperature	241 - 254	°C	
Front Temperature	246 - 260	°C	
Nozzle Temperature	246 - 260	°C	

Processing (Melt) Temp	246 - 266	°C
Mold Temperature	43.3 - 65.6	°C
Injection Rate	Fast	
Back Pressure	0.00 - 0.172	MPa
Clamp Tonnage	2.8 - 5.5	kN/cm²
Cushion	< 6.35	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	

Injection instructions
Hold Pressure: 50 to 70% of Injection PressureScrew Speed: Moderate

NOTE	
1.	Compression Molded
2.	标准 B (120°C/h)

Recommended distributors for this material

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