

Lustran® ABS 266

Acrylonitrile Butadiene Styrene

INEOS ABS (USA)

Message:

Lustran ABS 266 resin is a clear injection molding grade of ABS (acrylonitrile butadiene styrene). This transparent, general-purpose grade provides clarity and toughness with ease of processing. The resin is available in transparent tint, color code 000000.

A tough, transparent grade of ABS, Lustran ABS 266 resin is used in housings, toys, lawn and garden applications, and various consumer goods. As with any product, use of Lustran ABS 266 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	E44741-235633		
Features	Definition, high		
	Good toughness		
Uses	Lawn and Garden Equipment		
	Shell		
	Toys		
	Consumer goods application field		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Specific Volume	0.930	cm ³ /g	ASTM D792
Melt Mass-Flow Rate (MFR) (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)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1970	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	37.2	MPa	ASTM D638
Fracture	29.0	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	4.0	%	ASTM D638
Fracture	48	%	ASTM D638
Flexural Modulus	1770	MPa	ASTM D790
Flexural Strength (Yield)	58.6	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	86.7	°C	ASTM D648
0.45 MPa, unannealed, 12.7mm	93.9	°C	ASTM D648
1.8 MPa, unannealed, 3.18mm	72.8	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	82.2	°C	ASTM D648
CLTE - Flow	1.2E-4	cm/cm/°C	ASTM D696
RTI Elec (1.50 mm)	50.0	°C	UL 746
RTI Imp (1.50 mm)	50.0	°C	UL 746
RTI (1.50 mm)	50.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm, Clear	HB		UL 94
3.00 mm, Clear	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.520		ASTM D542
Transmittance (2540 µm)	86.0	%	ASTM D1003
Haze (2540 µm)	3.0	%	ASTM D1003
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	%	
Suggested Max Regrind	20	%	
Rear Temperature	193 - 221	°C	
Middle Temperature	199 - 227	°C	
Front Temperature	204 - 232	°C	
Nozzle Temperature	204 - 232	°C	
Processing (Melt) Temp	204 - 232	°C	
Mold Temperature	43.3 - 65.6	°C	
Injection Pressure	68.9 - 110	MPa	
Injection Rate	Fast		
Holding Pressure	34.5 - 82.7	MPa	
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	

Hold Pressure: 50 to 75% of Injection PressureScrew Speed: Moderate

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