

# Lustran® ABS 349

Acrylonitrile Butadiene Styrene  
Styrolution

Message:

Lustran ABS 349 is a high-gloss, medium-impact injection molding resin that has been specially formulated for excellent surface lubricity using internal additives.

General Information			
Features	Highlight		
	Lubrication		
	Medium impact resistance		
Agency Ratings	EC 1907/2006 (REACH)		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2620	MPa	ASTM D638
Tensile Strength (Yield)	42.1	MPa	ASTM D638
Flexural Modulus	2690	MPa	ASTM D790
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	87.8	°C	ASTM D648
Vicat Softening Temperature	104	°C	ASTM D1525 <sup>1</sup>
CLTE - Flow (-30 to 30°C)	8.1E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	82.2 - 87.8	°C	
Drying Time	2.0	hr	
Suggested Shot Size	50 - 75	%	
Processing (Melt) Temp	246 - 274	°C	
Mold Temperature	26.7 - 65.6	°C	
Injection Rate	Fast		
Back Pressure	0.00 - 0.172	MPa	

Cushion	< 3.18	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	

#### Injection instructions

Screw Speed: ModerateDrying at 160°-170°F for 4 hours is also adequate.

#### NOTE

1. 压力1 (10N)

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