

Lustran® ABS LGA

Acrylonitrile Butadiene Styrene
Styrolution

Message:

Lustran ABS LGA resin is a low-gloss grade of ABS (acrylonitrile butadiene styrene). This automotive injection molding grade offers an excellent balance of rigidity, impact strength, and abuse resistance. The resin is available in natural and black colors only. The consistent, clean, natural color of LGA makes it ideally suitable for use with color concentrates.

Lustran ABS LGA resin is designed to meet stringent physical property and appearance requirements for low-loss automotive interior trim applications. Typical uses are pillar posts, consoles, scuff plates, map pockets, and interior quarter trim panels. As with any product, use of Lustran ABS LGA 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	E44741-235659
Features	Rigidity, high
	Gloss, low
	Impact resistance, good
Uses	Application in Automobile Field
	Car interior parts
Agency Ratings	EC 1907/2006 (REACH)
Appearance	Black
	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	1.05	g/cm ³	ASTM D792
Specific Volume	0.950	cm ³ /g	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	21	g/10 min	ASTM D1238
230°C/3.8 kg	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2210	MPa	ASTM D638
Tensile Strength			

Yield	36.5	MPa	ASTM D638
Yield	39.0	MPa	ISO 527-2
Flexural Modulus			
--	2410	MPa	ASTM D790
--	2430	MPa	ISO 178
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C, 3.18 mm	170	J/m	ASTM D256
-40°C ¹	7.7	kJ/m ²	ISO 180/1A
23°C ²	16	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	90.0	°C	ASTM D648
0.45 MPa, unannealed, 12.7mm	92.2	°C	ASTM D648
0.45 MPa, annealed, 3.18mm	100	°C	ASTM D648
0.45 MPa, annealed, 12.7mm	102	°C	ASTM D648
1.8 MPa, unannealed, 3.18mm	76.1	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	87.2	°C	ASTM D648
1.8 MPa, annealed, 3.18mm	95.0	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	100	°C	ASTM D648
Vicat Softening Temperature			
--	107	°C	ASTM D1525 ³
--	96.0	°C	ISO 306/B50
CLTE - Flow (-30 to 30°C)	9.0E-5	cm/cm/°C	ASTM D696
RTI Elec (1.57 mm)	60.0	°C	UL 746
RTI Imp (1.57 mm)	60.0	°C	UL 746
RTI (1.57 mm)	60.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Burning Rate ⁴	53	mm/min	SAE J1685
Flame Rating			UL 94
1.57 mm	HB		UL 94
3.18 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	%	

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 Pressure	68.9 - 110	MPa
Injection Rate	Fast	
Back Pressure	0.345 - 0.689	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 Pressure Screw Speed: Moderate

NOTE

1. 4x10 mm bar
2. 4x10 mm bar
3. 标准 B (120°C/h), 压力1 (10N)
4. 2x100x355 mm

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