Lustran® SAN 29

Styrene Acrylonitrile

Styrolution

Message:

Lustran SAN 29 resin is an injection molding grade of transparent SAN (styrene acrylonitrile) thermoplastic. The base resin used in the Lustran SAN 29 product is in chemical compliance with 21 CFR 181.32 (acrylonitrile copolymers and resins) for use in the manufacture of repeated-use houseware articles. Lustran SAN 29 resin has the highest impact strength of the grades used for houseware articles in the Lustran SAN product line. Lustran SAN 29 in our standard tint (color code 552160) also meets U.S. Pharmacopeia 23 Class VI and ISO 10993-1 based on biocompatibility testing of the base polymer with higher levels of additives and colorants than used in this formulation. Lustran SAN 29 has a large molding window and is easy to process.

General Information			
UL YellowCard	E44741-235668		
Features	Impact resistance, high		
	Impact resistance, good		
	Workability, good		
	Scratch resistance		
	Good chemical resistance		
	alkali resistance		
	acid resistance		
	Oil resistance		
	Grease resistance		
Uses	Battery box		
	Household goods		
	Shell		
Agency Ratings	EC 1907/2006 (REACH)		
	FDA 21 CFR 181.32		
	ISO 10993-Part I		
	USP XXIII, Class VI		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm³	ASTM D792
Specific Volume	0.930	cm³/g	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	83		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	74.0	MPa	ASTM D638
Flexural Modulus	3400	MPa	ASTM D790
Flexural Strength (Yield)	130	MPa	ASTM D790
Deformation Under Load (50°C, 28 MPa)	1.50	%	ASTM D621
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	21	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	250	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	96.0	°C	ASTM D648
Vicat Softening Temperature	111	°C	ASTM D1525 ¹
CLTE - Flow	6.8E-5	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, CL	НВ		UL 94
3.00 mm, CL	НВ		UL 94
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.570		ASTM D542
Transmittance (3200 μm)	87.0 - 88.0	%	ASTM D1003
Haze (3200 µm)	0.80	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature			
А	82.0 - 88.0	°C	
В	71.0 - 77.0	°C	
Drying Time			
А	2.0	hr	
В	4.0	hr	
Suggested Max Moisture	0.20	%	
Suggested Shot Size	50 - 70	%	
Suggested Max Regrind	20	%	
Rear Temperature	170 - 185	°C	
Middle Temperature	185 - 200	°C	
Front Temperature	200 - 215	°C	
Nozzle Temperature	200 - 215	°C	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	40.0 - 80.0	°C	
Injection Pressure	68.9 - 138	MPa	
Injection Rate	Moderate-Fast		

Back Pressure	0.00 - 0.172	MPa		
Clamp Tonnage	2.8 - 5.5	kN/cm ²		
Cushion	3.18	mm		
Screw L/D Ratio	20.0:1.0			
Screw Compression Ratio	2.5:1.0			
Injection instructions				
Screw Speed: ModerateInlet Air Dew Point: -20°FHold Pressure: 40 to 80% of the injection pressure				
NOTE				
1.	标准 B (120°C/h)			

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