

Lustran® ABS 451

Acrylonitrile Butadiene Styrene

Styrolution

Message:

Lustran ABS 451 is a soft flowing, medium impact injection molding resin designed with a unique balance of impact, heat resistance, flow and gloss. As with any product, use of Lustran ABS 451 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	E44741-235638		
Features	Gloss, Medium		
	Good liquidity		
	Heat resistance, medium		
	Medium impact resistance		
Agency Ratings	EC 1907/2006 (REACH)		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	4.4	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2620	MPa	ASTM D638
Tensile Strength (Yield)	42.7	MPa	ASTM D638
Flexural Modulus	2590	MPa	ASTM D790
Flexural Strength (Yield)	74.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-18°C, 3.18 mm	69	J/m	ASTM D256
23°C, 3.18 mm	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 12.7mm	80.6	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	102	°C	ASTM D648
Vicat Softening Temperature	96.1	°C	ASTM D1525 ¹
CLTE - Flow	8.3E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating			UL 94

1.50 mm	HB	UL 94
3.00 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 Shot Size	50 - 75	%
Processing (Melt) Temp	232 - 274	°C
Mold Temperature	43.3 - 65.6	°C
Injection Rate	Moderate-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	
Vent Depth	0.051	mm
Injection instructions		
Screw Speed: ModerateScrew Delay: to minimize residence		
NOTE		

1. 标准 B (120°C/h), 压力1 (10N)

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