

Lustran® ABS 433

Acrylonitrile Butadiene Styrene
Styrolution

Message:

Lustran® ABS 433 is a general-purpose injection molding grade of ABS (Acrylonitrile Butadiene Styrene). It is a highimpact, high-gloss ABS, available only in natural (000000) and black (904000). In its natural color (000000), Lustran ABS 433 meets FDA requirements for food contact. Typical applications include housings, toys, small appliances, and consumer goods. As with any product, use of Lustran ABS 433 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	E44741-235636		
Features	Highlight		
	Impact resistance, high		
	Compliance of Food Exposure		
Uses	Electrical appliances		
	Shell		
	Toys		
	Consumer goods application field		
Agency Ratings	EC 1907/2006 (REACH)		
	FDA Food Exposure, Not Rated 3		
RoHS Compliance	RoHS compliance		
Appearance	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	12	g/10 min	ASTM D1238
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)	109		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2550	MPa	ASTM D638
Tensile Strength (Yield)	42.1	MPa	ASTM D638

Tensile Elongation (Break)	30	%	ASTM D638
Flexural Modulus	2620	MPa	ASTM D790
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	64	J/m	ASTM D256
23°C, 3.18 mm	370	J/m	ASTM D256
23°C, 12.7 mm	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 12.7mm	91.7	°C	ASTM D648
0.45 MPa, annealed, 12.7mm	99.4	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	85.0	°C	ASTM D648
1.8 MPa, annealed, 12.7mm, molded	102	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	94.4	°C	ASTM D648
Vicat Softening Temperature	106	°C	ASTM D1525 ¹
CLTE - Flow	9.0E-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 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 - 274	°C	
Mold Temperature	43.3 - 65.6	°C	
Injection Pressure	68.9 - 110	MPa	
Injection Rate	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: ModerateHold Pressure: 50 to 70% of the injection pressure	
NOTE	
1.	标准 B (120°C/h)

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