

# Lustran® SAN DN59

Styrene Acrylonitrile

INEOS ABS (USA)

## Message:

Lustran SAN DN59 resin is a soft-flow grade of transparent SAN (styrene acrylonitrile) thermoplastic. It has been designed for use in compounding and thin-wall injection molded applications. Lustran SAN DN59 has a large molding window and is easy to process. It is available only in natural (000000) color.

As with any product, use of Lustran SAN DN59 resin in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

General Information			
Features	Workability, good		
	Good liquidity		
	Definition, high		
Uses	Thin wall parts		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Clear/transparent		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm <sup>3</sup>	ASTM D792
Specific Volume	0.930	cm <sup>3</sup> /g	ASTM D792
Acrylonitrile Content	29.5	%	
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4710	MPa	ISO 527-2
Tensile Stress (Break)	58.0	MPa	ISO 527-2
Flexural Modulus	3760	MPa	ISO 178
Flexural Stress <sup>1</sup>	91.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.5	kJ/m <sup>2</sup>	ISO 180
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	106	°C	ISO 306/A120
--	99.5	°C	ISO 306/B50
--	102	°C	ISO 306/B120
Injection	Nominal Value	Unit	

Drying Temperature		
A	82.0 - 88.0	°C
B	71.0 - 77.0	°C
Drying Time		
A	2.0	hr
B	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	Fast	
Back Pressure	0.00 - 0.172	MPa
Clamp Tonnage	2.8 - 5.5	kN/cm <sup>2</sup>
Cushion	< 3.18	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	
Injection instructions		
Hold Pressure: 40 to 80% of Injection PressureScrew Speed: Moderate		
NOTE		

1. Yield

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