

Lustran ABS 633

Acrylonitrile Butadiene Styrene
Styrolution

Message:

Lustran ABS 633 resin is a general-purpose injection molding grade of ABS (acrylonitrile butadiene styrene). It offers a good balance of physical properties, high gloss, and good moldability.
Typical applications include housings, toys, small appliances, and consumer goods. As with any product, use of Lustran ABS 633 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	E44741-235647		
Features	Highlight		
	Good formability		
	General		
Uses	Electrical appliances		
	Toys		
	Consumer goods application field		
Agency Ratings	EC 1907/2006 (REACH)		
Forms	Particle		
Processing Method	Injection molding		
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
230°C/10.0 kg	15	g/10 min	ASTM D1238
230°C/3.8 kg	4.5	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	2200	MPa	ASTM D638
Tensile Strength (Yield)	41.3	MPa	ASTM D638
Flexural Modulus	2200	MPa	ASTM D790
Flexural Strength (Yield)	65.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ¹			ASTM D256
-40°C, 3.20 mm	64	J/m	ASTM D256
23°C, 3.20 mm	350	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 12.7mm	96.0	°C	ASTM D648
0.45 MPa, annealed, 12.7mm	102	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	85.0	°C	ASTM D648
1.8 MPa, annealed, 12.7mm	97.0	°C	ASTM D648
Vicat Softening Temperature	106	°C	ASTM D1525 ²
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
RTI Elec (1.50 mm)	60.0	°C	UL 746
RTI Imp (1.50 mm)	60.0	°C	UL 746
RTI (1.50 mm)	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Optical	Nominal Value		Test Method
Gardner Gloss (60°)	90		ASTM D523
Injection	Nominal Value	Unit	
Drying Temperature			
A	82.0 - 88.0	°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	< 6.35	mm	
Screw L/D Ratio	20.0:1.0		
Screw Compression Ratio	2.5:1.0		
Injection instructions			
Hold Pressure: 50 to 70% of the injection pressureScrew Speed: Moderate			
NOTE			

1.	13mm notch depth
2.	标准 B (120°C/h)

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