

Ineos ABS Lustran® 633 ABS, Injection Molding Grade

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Molded

Material Notes:

Lustran® ABS 633 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.

Order this product through the following link:

http://www.lookpolymers.com/polymer_ineos-ABS-Lustran-633-ABS-Injection-Molding-Grade.php

Physical Properties	Metric	English	Comments
Density	1.05 g/cc	0.0379 lb/in ³	ASTM-D792
Linear Mold Shrinkage	0.0040 - 0.0060 cm/cm	0.0040 - 0.0060 in/in	ASTM-D955
Melt Flow	4.5 g/10 min	4.5 g/10 min	ASTM-D1238
	@Load 3.80 kg, Temperature 230 Â°C	@Load 8.38 lb, Temperature 446 Â°F	
	14.5 g/10 min	14.5 g/10 min	ASTM-D1238
	@Load 10.0 kg, Temperature 230 Â°C	@Load 22.0 lb, Temperature 446 Â°F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	109	109	ASTM-D785
Tensile Strength, Yield	41.3 MPa	5990 psi	ASTM-D638
Tensile Modulus	2.20 GPa	319 ksi	ASTM-D638
Flexural Yield Strength	65.5 MPa	9500 psi	ASTM-D790
Flexural Modulus	2.20 GPa	319 ksi	ASTM-D790
Izod Impact, Notched	0.640 J/cm	1.20 ft-lb/in	ASTM-D256
	@Thickness 3.20 mm, Temperature -40.0 Â°C	@Thickness 0.126 in, Temperature -40.0 Â°F	
	3.47 J/cm	6.50 ft-lb/in	ASTM-D256
	@Thickness 3.20 mm, Temperature 23.0 Â°C	@Thickness 0.126 in, Temperature 73.4 Â°F	

Thermal Properties	Metric	English	Comments
CTE, linear	90.0 Âµm/m-Â°C	50.0 Âµin/in-Â°F	ASTM-D696
Deflection Temperature at 0.46 MPa (66 psi)	96.0 Â°C	205 Â°F	Unannealed; ASTM-D648
	@Thickness 12.7 mm	@Thickness 0.500 in	

Thermal Properties	Metric	English	Comments
	102 Â°C	214 Â°F	
	@Thickness 12.7 mm	@Thickness 0.500 in	Annealed; ASTM-D648
Deflection Temperature at 1.8 MPa (264 psi)	85.0 Â°C	185 Â°F	
	@Thickness 12.7 mm	@Thickness 0.500 in	Unannealed; ASTM-D648
	97.0 Â°C	207 Â°F	
	@Thickness 12.7 mm	@Thickness 0.500 in	Annealed; ASTM-D648
Vicat Softening Point	106 Â°C	223 Â°F	Rate B; ASTM-D1525
UL RTI, Electrical	60.0 Â°C	140 Â°F	
	@Thickness 1.50 mm	@Thickness 0.0591 in	UL746B
UL RTI, Mechanical with Impact	60.0 Â°C	140 Â°F	
	@Thickness 1.50 mm	@Thickness 0.0591 in	UL746B
UL RTI, Mechanical without Impact	60.0 Â°C	140 Â°F	
	@Thickness 1.50 mm	@Thickness 0.0591 in	UL746B
Flammability, UL94	HB	HB	
	@Thickness 1.50 mm	@Thickness 0.0591 in	
	HB	HB	
	@Thickness 3.00 mm	@Thickness 0.118 in	

Optical Properties	Metric	English	Comments
Gloss	90 %	90 %	Angle 60Â°; ASTM-D523

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	235 - 249 Â°C	455 - 480 Â°F	Injection Molding
Middle Barrel Temperature	241 - 254 Â°C	466 - 489 Â°F	Injection Molding
Front Barrel Temperature	246 - 260 Â°C	475 - 500 Â°F	Injection Molding
Nozzle Temperature	246 - 260 Â°C	475 - 500 Â°F	Injection Molding
Melt Temperature	246 - 274 Â°C	475 - 525 Â°F	Injection Molding
Mold Temperature	43.0 - 66.0 Â°C	109 - 151 Â°F	Injection Molding
Drying Temperature	71.0 - 77.0 Â°C	160 - 171 Â°F	
	@Time 14400 sec	@Time 4.00 hour	

Processing Properties	82.0 - 88.0 Â°C Metric	180 - 190 Â°F English	Comments
	@Time 7200 sec	@Time 2.00 hour	
Moisture Content	<= 0.10 %	<= 0.10 %	
Dew Point	<= -29.0 Â°C	<= -20.2 Â°F	inlet air
Injection Pressure	68.9 - 110 MPa	10000 - 16000 psi	Injection Molding
Back Pressure	0.000 - 0.172 MPa	0.000 - 25.0 psi	Injection Molding
Clamp Pressure	30.8 - 61.6 MPa	4470 - 8930 psi	Injection Molding
Cushion	<= 0.635 cm	<= 0.250 in	Injection Molding

Descriptive Properties	Value	Comments
Hold Pressure	50-75% of Injection Pressure, Injection Molding	
Injection Speed	High	Injection Molding
Screw Compression Ratio	2.5:1	Injection Molding
Screw Length-to-Diameter Ratio	>= 20:1	Injection Molding
Screw Speed	Moderate, Injection Molding	
Shot Weight-to-Machine Capacity Ratio	0.5-0.75	Injection Molding

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