

Ineos ABS Lustran® 256 Extrusion Blending Grade

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

Material Notes:

Lustran® ABS 256 resin is a natural, medium-flow, medium-impact, low-gloss, low-gel extrusion grade of ABS (Acrylonitrile Butadiene Styrene). It is used for blending with other Lustran® ABS virgin and regrind materials to optimize cost and performance.

Order this product through the following link:

http://www.lookpolymers.com/polymer_ineos-ABS-Lustran-256-Extrusion-Blending-Grade.php

Physical Properties	Metric	English	Comments
Density	1.05 g/cc	0.0379 lb/in ³	ASTM-D792
Melt Flow	14 g/10 min @Load 10.0 kg, Temperature 230 °C	14 g/10 min @Load 22.0 lb, Temperature 446 °F	ASTM-D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	40.0 MPa	5800 psi	ASTM-D638
Tensile Modulus	2.20 GPa	319 ksi	ASTM-D638
Flexural Yield Strength	69.0 MPa	10000 psi	ASTM-D790
Flexural Modulus	2.40 GPa	348 ksi	ASTM-D790
Izod Impact, Notched	0.480 J/cm @Thickness 3.20 mm, Temperature -40.0 °C	0.899 ft-lb/in @Thickness 0.126 in, Temperature -40.0 °F	ASTM-D256
	0.850 J/cm @Thickness 3.20 mm, Temperature -18.0 °C	1.59 ft-lb/in @Thickness 0.126 in, Temperature -0.400 °F	ASTM-D256
	1.60 J/cm @Thickness 3.20 mm, Temperature 23.0 °C	3.00 ft-lb/in @Thickness 0.126 in, Temperature 73.4 °F	ASTM-D256
Impact Test	12.0 J @Temperature -40.0 °C	8.85 ft-lb @Temperature -40.0 °F	Instrumented Impact (0.5-in. dart, 3-in. clamp, 7.6 mph); Peak Energy; ASTM-D3763
	14.0 J @Temperature -40.0 °C	10.3 ft-lb @Temperature -40.0 °F	Instrumented Impact (0.5-in. dart, 3-in. clamp, 7.6 mph); Total Energy; ASTM-D3763
	15.0 J	11.1 ft-lb	Instrumented Impact (0.5-in. dart, 3-

Mechanical Properties	Metric	English	Comments
	@Temperature -18.0 Â°C	@Temperature -0.400 Â°F	in. clamp, 7.6 mph); Peak Energy; ASTM-D3763
	16.0 J	11.8 ft-lb	Instrumented Impact (0.5-in. dart, 3-in. clamp, 7.6 mph); Total Energy; ASTM-D3763
	@Temperature -18.0 Â°C	@Temperature -0.400 Â°F	
	24.0 J	17.7 ft-lb	Instrumented Impact (0.5-in. dart, 3-in. clamp, 7.6 mph); Peak Energy; ASTM-D3763
	@Temperature 23.0 Â°C	@Temperature 73.4 Â°F	
	30.0 J	22.1 ft-lb	Instrumented Impact (0.5-in. dart, 3-in. clamp, 7.6 mph); Total Energy; ASTM-D3763
	@Temperature 23.0 Â°C	@Temperature 73.4 Â°F	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	87.0 Â°C	189 Â°F	Unannealed; ASTM-D648

Optical Properties	Metric	English	Comments
Gloss	25 %	25 %	Formed, Angle 60Â°; ASTM-D523
	90 %	90 %	Sheet, Angle 60Â°; ASTM-D523

Processing Properties	Metric	English	Comments
Die Temperature	210 - 241 Â°C	410 - 466 Â°F	
Melt Temperature	215 - 240 Â°C	419 - 464 Â°F	Extruder
Roll Temperature	47.0 Â°C	117 Â°F	Down Stack, Middle
	82.0 Â°C	180 Â°F	Up Stack, Bottom
	88.0 Â°C	190 Â°F	Up Stack, Middle
	93.0 Â°C	199 Â°F	Down Stack, Bottom
	93.0 Â°C	199 Â°F	Up Stack, Top
	93.0 Â°C	199 Â°F	Down Stack, Top
Drying Temperature	82.0 - 93.0 Â°C @Time 10800 - 14400 sec	180 - 199 Â°F @Time 3.00 - 4.00 hour	
Moisture Content	<= 0.030 %	<= 0.030 %	
Dew Point	<= -29.0 Â°C	<= -20.2 Â°F	inlet air

Descriptive Properties	Value	Comments
Pump Ratio	1.5-2.0	Screw Design
Screw Compression Ratio	2.5-2.7	

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