INEOS ABS

LUSTRAN® ABS 1146

ABS (SAE J1685: ABS0121)
Automotive Grade

Description
Lustran ABS 1146 resin is a very high-impact grade of ABS (acrylonitrile butadiene styrene). This automotive injection molding grade offers a good balance of physical properties with high ductility at low temperatures.

Applications
Lustran ABS 1146 resin is used for automotive applications where impact strength and a non-brittle type of failure mode are needed. Typical applications include interior trim parts, lower steering column shrouds, glove box doors, tail lamp housings, and instrument panel carriers. As with any product, use of Lustran ABS 1146 resin in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

Drying
Drying prior to processing is recommended in a desiccant dehumidifying hopper dryer. An inlet air dew point of -20°F (-29°C) or below is recommended to achieve a moisture content ≤0.1%. Typical drying conditions are 2 hours at 180°-190°F (82°-88°C). Drying for 4 hours at 160°-170°F (71°-77°C) is also adequate.

Processing
A reciprocating screw injection molding machine is preferred. A general purpose screw with a 2.5:1 compression ratio is suggested. A minimum L/D ratio of 20:1 will ensure melt homogeneity.

For best part quality, use the lower range of the recommended melt temperature with minimum barrel residence time. To avoid excessive residence time in the barrel, volume and weight of the shot should be balanced against barrel capacity and injection stroke. A shot weight-to-machine capacity ratio of 0.5–0.75 is recommended.

A mold temperature of 120°–160°F (50–70°C) is recommended for development of maximum gloss and strength, with the hotter end of this range preferred.

Typical processing parameters are noted below. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.

Typical Injection Molding Conditions

Barrel Temperatures:	
Rear	460° – 490°F (240° – 255°C)
Middle	470° – 500°F (245° – 260°C)
Front	480° – 510°F (250° – 265°C)
Nozzle	480° – 510°F (250° – 265°C)
Melt Temperature	480° – 520°F (250° – 270°C)
Mold Temperature	120° – 160°F (50° – 70°C)
Injection Pressure	13,000 – 20,000 psi
Hold Pressure	50 – 75% of Injection Pressure
Back Pressure	25 – 100 psi
Screw Speed	Moderate
Injection Speed	High
Cushion	1/4 in max
Clamp	2 – 4 ton/in^2

Achieving uniform surface appearance on a molded part requires proper tool design, properly prepared and conditioned tool cavity surfaces, and preventive maintenance. Tool design should include adequate, properly sized, and properly designed vents. Preventive maintenance for tooling requires, but is not limited to, periodic inspection and cleaning of tool surfaces, actual cavity surfaces, and cavity vents.

Additional information on processing may be obtained by contacting an INEOS ABS technical service representative.

Typical Properties* for Natural Resin	ASTM Test Method (Other)[a]	Units U.S. Conventional	Units SI Metric	Lustran® 1146 ABS Resin U.S.	Lustran® 1146 ABS Resin SI
General					
Specific Gravity	D 792			1.03	
Density	D 792	lb/in³	g/cm³	0.037	1.03
Specific Volume	D 792	in³/lb	cm³/g	26.9	0.97
Mold Shrinkage	D 955	in/in	mm/mm	0.006–0.008	
Melt Flow Rate: 220°C/10-kg Load	D 1238	g/10 min		4	
230°C/3.8-kg Load		g/10 min		1	
Mechanical					
Tensile Stress at Yield	D 638	lb/in²	MPa	5,700	39
	(ISO 527)		MPa		42
Tensile Modulus	D 638	lb/in²	MPa	340,000	2,340
Flexural Stress at Yield	D 790	lb/in²	MPa	9,400	65
Flexural Modulus	D 790	lb/in²	MPa	350,000	2,410
	(ISO 178)		MPa		2,390
Impact Strength, Notched Izod:					
0.125-in (3.2-mm) Thickness, 73°F (23°C)	D 256	ft·lb/in	J/m	9.5	507
4 x 10-mm Bar, 73°F (23°C)	(ISO 180/1A)		kJ/m²		38.1
Rockwell Hardness	D 785	R Scale		100	
Thermal					
Deflection Temperature Under Load:	D 648				
Unannealed					
0.125-in (3.2-mm) Thickness, 264 psi		°F	°C	173	78
0.125-in (3.2-mm) Thickness, 66 psi		°F	°C	198	92
Annealed					
0.5-in (12.7-mm) Thickness, 264 psi		°F	°C	203	95
0.5-in (12.7-mm) Thickness, 66 psi		°F	°C	212	100
Annealed, Compression Molded					
0.5-in (12.7-mm) Thickness, 264 psi		°F	°C	221	105
Coefficient of Linear Thermal Expansion:	D 696				
-22° to 86°F (-30° to 30°C)		in/in/°F	mm/mm/°C	5.1 E-05	9.2 E-05
Relative Temperature Index:	(UL746B)				
0.062-in (1.57-mm) Thickness					
Electrical		°F	°C	140	60
Mechanical with Impact		°F	°C	140	60
Mechanical without Impact		°F	°C	140	60
Vicat Softening Temperature:					
1-kg Load, 120°C/Hour	D 1525	°F	°C	223	106
50-N Load, 50°C/Hour	(ISO 306)		°C		96
Flammability**					
UL94 Flame Class:	(UL94)				
0.062-in (1.57-mm) Thickness		Rating		HB	
0.125-in (3.18-mm) Thickness		Rating		HB	
Plaque Burn Rate:	(SAE J1685)				
0.079 x 4 x 14 in (2 x 100 x 355 mm)		in/min	mm/min	1.0	25

** These items are provided as general information only. They are approximate values and are not part of the product specifications.*

*** Flammability results are based on small-scale laboratory tests for purposes of relative comparison and are not intended to reflect the hazards presented by this or any other material under actual fire conditions.*

[a] Conditions for testing ABS under ISO standards are specified in ISO 2580-2.

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