

LUSTRAN[®] ABS 241

ABS

Blending Grade for DWV Pipe and Fittings

Description

Lustran ABS 241 resin is a natural, stiffer-flow, virgin blending grade of ABS (acrylonitrile butadiene styrene). It is designed for use with other high-impact ABS resins for drain, waste, and vent (DWV) pipe and fittings. Lustran ABS 241 resin in natural color (000000) meets or exceeds ASTM D 3965 1-1-2-2-2 cell class requirements. It is also listed under NSF Standard 14. As with any product, use of Lustran ABS 241 resin in a given application must be tested (including but not limited to field testing) 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 of 0.05% maximum. Typical drying conditions are 2 hours at 180°-200°F (82°-93°C).

Processing for Injection Molding

The following processing parameters are recommended when using blends to injection-mold DWV fittings. Actual processing conditions will depend on machine size, mold design, material residence time, and shot size.

Typical Injection Molding Conditions	
Melt Temperature.....	450° – 470°F (232° – 243°C)
Mold Temperature.....	110° – 150°F (43° – 66°C)
Injection Pressure.....	Moderately High to High
Injection Speed.....	Moderate to Fast
Cushion	Minimum

Please consult an INEOS ABS technical service representative for additional information on blending for injection molding.

Processing for Extrusion

The following processing parameters are recommended when using blends to extrude DWV pipe.

Screw Design. Good extrusion characteristics are obtained on a variety of screw types, such as conventional single- and two-stage metering and single- and two-stage high-shear screws, which utilize mixing rings or multiple flight configurations. Typically, best performance has been observed with those screws having compression ratios between 2.4 and 2.8:1 and length-to-diameter ratios of 24 to 36:1.

Dies. Interiors should be streamlined with smooth, chrome-plated surfaces to minimize stock hang-up and degradation. Thin, tear-drop spider vanes are highly recommended to maximize weld-line strength. Welds are further strengthened by compressing the melt in the final die lip approach. For Schedule 40 pipe that is 4 inches and under in diameter, a land length-to-pin clearance ratio of 25:1 is preferred. Dies for larger-diameter and/or heavier-wall pipe may require higher ratios or pin chokes.

Melt Temperature. Optimum pipe properties are obtained when melt temperatures are between 450° and 470°F (232° and 243°C). Temperatures above 500°F (260°C) are not recommended since these can lead to degradation on the inner pipe walls.

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

Typical Properties* for Natural (000000) Resin	ASTM Test Method (Other)	Lustran® ABS 241 Resin**	
		U.S. Conventional	SI Metric
General			
Specific Gravity	D 792		1.05
Density	D 792	0.038 lb/in ³	1.05 g/cm ³
Specific Volume	D 792	26.4 in ³ /lb	0.95 cm ³ /g
Melt Flow Rate at 220°C/10-kg Load	D 1238		15.0 g/10 min
Mechanical			
Tensile Stress at Yield	D 638	6,000 lb/in ²	39 MPa
Tensile Modulus	D 638	360,000 lb/in ²	2.5 GPa
Impact Strength, Notched Izod: 0.125-in (3.2-mm) Thickness	D 256		
73°F (23°C)		2.6 ft-lbs/in	139 J/m
-22°F (-30°C)		1.5 ft-lbs/in	80 J/m
Thermal			
Deflection Temperature Under Load, Annealed: 0.250-in (6.4-mm) Thickness 264 psi (1.82 MPa) Load	D 648		
		216°F	102°C

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

** Property values obtained on injection molded specimens unless otherwise noted.

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