

LUSTRAN[®] ABS 261

ABS

High-Impact Blending Grade for DWV Pipe and Fittings

Description

Lustran ABS 261 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 261 resin in natural color (000000) meets or exceeds ASTM D 3965 3-1-5-2-2 cell class requirements, and is listed under NSF Standard 14. Lustran ABS 261 resin is also listed under CSA Standard B181.1. As with any product, use of Lustran ABS 261 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.

Regrind Information

Generally ABS regrind can be used up to 40% with virgin ABS as long as the regrind is clean and uncontaminated with other materials and properly dried. However, DWV pipe and fittings are regulated by NSF under Standard 14 and by CSA under Standard B181.1.

NSF Standard 14 restricts the use of regrind. Each processor must submit samples and obtain specific approval from NSF to utilize any regrind. NSF, after review and testing, has allowed the use of in-plant line scrap, which would be the processor's regrind, up to about 10%. For more information, consult NSF Standard 14 or call NSF.

Typical Properties* for Natural Resin	ASTM Test Method (Other)	Lustran® ABS 261 Resin**	
		U.S. Conventional	SI Metric
General Specific Gravity Density Specific Volume Melt Flow Rate at 230°C/10-kg Load Melt Flow Index at 220°C/10-kg Load	D 792 D 792 D 792 D 1238	1.05 0.038 lb/in ³ 26.4 in ³ /lb	1.05 g/cm ³ 0.95 cm ³ /g 11.0 g/10 min 6.0 g/10 min
Mechanical Tensile Stress at Yield Tensile Modulus Impact Strength, Notched Izod: 0.125-in (3.2-mm) Thickness 73°F (23°C) -22°F (-30°C)	D 638 D 638 D 256	5,400 lb/in ² 290,000 lb/in ² 4.8 ft-lb/in 2.1 ft-lb/in	37 MPa 2.0 GPa 256 J/m 112 J/m
Thermal Deflection Temperature, Annealed: 0.250-in (6.4-mm) Thickness 264 psi (1.82 MPa) Load	D 648	214°F	101°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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INEOS ABS (USA) Corporation