

LUSTRAN[®] SMA 2316

SMA

16% Glass-Reinforced Grade

Description

Lustran SMA 2316 is a 16% glass-reinforced molding grade of impact-modified SMA (styrene/maleic anhydride) terpolymer offering an exceptional balance of processability and performance. Lustran SMA 2316 has high heat resistance coupled with rigidity and decorability, making it an ideal choice for automotive instrument panel and console applications. As with any product, use of Lustran SMA 2316 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 ≤ 0.1%. Typical drying conditions are 2-3 hours at 180°-200°F (82°-93°C).

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.

Use minimum melt temperature with minimum barrel residence time, consistent with good part quality. 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.

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

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°– 510°F (250°– 265°C)
Mold Temperature.....	140°– 180°F (60°– 85 °C)
Back Pressure.....	25 – 50 psi
Screw Speed.....	Moderate
Injection Speed.....	Moderate
Cushion	1/4 in max
Clamp.....	2 – 4 ton/in ²

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

Health and Safety Information

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling the INEOS ABS products mentioned in this publication. For materials mentioned which are not INEOS ABS products, appropriate industrial hygiene and other safety precautions recommended by their manufacturers should be followed. Before working with any of these products, you must read and become familiar with the available information on their hazards, proper use, and handling. This cannot be overemphasized. Information is available in several forms, *e.g.*, *material safety data sheets and product labels*. Consult your INEOS ABS representative or contact the Product Safety and Regulatory Affairs Department at INEOS ABS.

Typical Properties* for Natural Resin	ISO Test Method (Other)	Lustran® SMA 2316 Resin
General Specific Gravity Density Mold Shrinkage Parallel to Flow Cross to Flow Melt Flow Rate at 220°C/10-kg Load Glass Level	(ASTM D 792) ISO 1183 ISO 2577 (ASTM D 1238)	1.2 1.198 g/cm ³ 0.028% 0.035% 3.3 g/10 min 16%
Mechanical Tensile Stress at Yield: -30°C 23°C 85°C 107°C Tensile Stress at Yield Tensile Stress at Fail, 23°C Tensile Modulus, 23°C Tensile Modulus Flexural Stress at Yield Flexural Stress at Yield Flexural Modulus Flexural Modulus Impact Strength, Notched Izod (4x10 mm): 23°C -40°C Impact Strength, Notched Izod (0.5 x 0.125 in): 23°C -30°C Impact Strength, Charpy Notched: 23°C -30°C	ISO 527 (ASTM D 638) ISO 527 ISO 527 (ASTM D 638) ISO 178 (ASTM D 790) ISO 178 (ASTM D 790) ISO 180/1A (ASTM D 256) ISO 179/1eA	90.1 MPa 83.6 MPa 65.4 MPa 56.2 MPa 11,280 lb/in ² 84.7 MPa 5,780 MPa 797,000 lb/in ² 129 MPa 18,000 lb/in ² 5,290 MPa 637,000 lb/in ² 9.5 kJ/m ² 8.1 kJ/m ² 1.6 ft-lbs/in 1.3 ft-lbs/in 10.6 kJ/m ² 7.7 kJ/m ²
Thermal Deflection Temperature Under Load (4-mm): 18 MPa 0.46 MPa Deflection Temperature Under Load (0.5 x 0.125-in): 264 psi 64 psi Vicat Softening Temperature: 5-kg, 50°C/hour Vicat Softening Temperature, Method C: 1-kg, 120°C/hour Coefficient of Linear Thermal Expansion: Flow Cross-Flow	ISO 75-2A (ASTM D 648) ISO 306 (ASTM D 1525) ISO 11359-2	121°C 129°C 103°C 128°C 125.9°C 141°C 0.000041 mm/mm/°C 0.000047 mm/mm/°C
Other Burn Rate Poissons Ratio: Flow Direction Cross-Flow Direction	(SAE J 369) ISO 527	29.2 mm/min 0.41 0.39

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

Note: The information contained in this publication is current as of July 2012. Please contact INEOS ABS to determine whether this publication has been revised.

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