



Americas Styrenics MB3150

Americas Styrenics LLC - General Purpose Polystyrene

Tuesday, November 5, 2019

General Information

General

Material Status	<ul style="list-style-type: none"> Commercial: Active 		
Availability	<ul style="list-style-type: none"> North America 		
Features	<ul style="list-style-type: none"> Crystal Fast Molding Cycle 	<ul style="list-style-type: none"> Food Contact Acceptable Good Toughness 	<ul style="list-style-type: none"> High Clarity High Heat Resistance
Uses	<ul style="list-style-type: none"> Consumer Applications Containers 	<ul style="list-style-type: none"> Media Packaging Vials 	
Agency Ratings	<ul style="list-style-type: none"> FDA 21 CFR 177.1640 		
UL File Number	<ul style="list-style-type: none"> E326906 		
Appearance	<ul style="list-style-type: none"> Clear - Blue Tint 		
Forms	<ul style="list-style-type: none"> Pellets 		
Processing Method	<ul style="list-style-type: none"> Extrusion Injection Molding 		

ASTM & ISO Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (200°C/5.0 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	4.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical			
Tensile Modulus (Injection Molded)	450000	psi	ASTM D638
Tensile Strength (Injection Molded)	7400	psi	ASTM D638
Tensile Strength (Break, Injection Molded)	7400	psi	ASTM D638
Tensile Elongation (Break, Injection Molded)	3.0	%	ASTM D638
Flexural Modulus (Injection Molded)	475000	psi	ASTM D790
Flexural Strength (Injection Molded)	12000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, Injection Molded)	0.39	ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness (L-Scale)	108		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	208	°F	ASTM D648
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	190	°F	
Vicat Softening Temperature	225	°F	ASTM D1525
CLTE - Flow	5.0E-5	in/in/°F	ASTM D696
Flammability			
Flame Rating	HB		UL 94

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Processing Information

Injection	Nominal	Value	Unit
Rear Temperature	446 to 473	°F	
Middle Temperature	419 to 446	°F	
Front Temperature	392 to 419	°F	
Nozzle Temperature	446 to 473	°F	
Mold Temperature	60 to 150	°F	
Injection Rate	Fast		
Back Pressure	29.0 to 218	psi	
Cushion	0.250	in	
Extrusion	Nominal	Value	Unit
Cylinder Zone 1 Temp.	351 to 379	°F	
Cylinder Zone 2 Temp.	360 to 399	°F	
Cylinder Zone 3 Temp.	370 to 410	°F	
Cylinder Zone 4 Temp.	390 to 421	°F	
Cylinder Zone 5 Temp.	399 to 430	°F	
Adapter Temperature	379 to 450	°F	
Melt Temperature	379 to 450	°F	
Die Temperature	390 to 450	°F	

Extrusion Notes

Zone 6 Temperature: 204 to 221°C

Melt Pump, Pipes, Screen Changer Temperature: 193 to 232°C

Polish Rolls Temperature: 66 to 104°C

Head Pressure: 10 to 21 MPa

Notes

¹ Typical properties: these are not to be construed as specifications.