

Network Polymers San 250

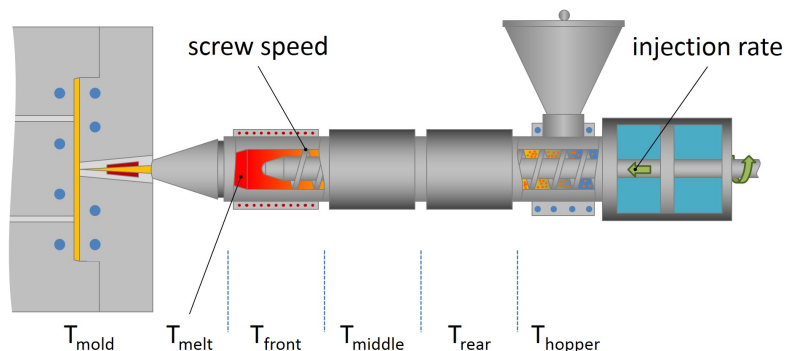
Styrene Acrylonitrile
LyondellBasell Industries
Engineering Plastics

General			
Appearance	• Natural Color		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.07	1.07 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (200°C/5.0 Kg)	0.90 g/10 min	0.90 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	11700 psi	80.7 MPa	ASTM D638
Flexural Modulus	519000 psi	3580 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.252 In (6.40 Mm)	0.20 ft·lb/in	11 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-scale)	122	122	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 Psi (1.8 Mpa), Unannealed, 0.252 In (6.40 Mm)	196 °F	91.1 °C	ASTM D648
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	160 to 180 °F	71 to 82 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Shot Size	40 to 75 %	40 to 75 %
Rear Temperature	320 to 360 °F	160 to 182 °C
Middle Temperature	360 to 430 °F	182 to 221 °C
Front Temperature	380 to 450 °F	193 to 232 °C
Nozzle Temperature	380 to 450 °F	193 to 232 °C
Processing (Melt) Temp	380 to 420 °F	193 to 216 °C
Mold Temperature	80 to 170 °F	27 to 77 °C
Injection Pressure	60.0 to 1100 psi	0.414 to 7.58 MPa
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa
Clamp Tonnage	2.0 to 3.0 tons/in ²	2.8 to 4.1 kN/cm ²

