

STYRON™ 668

General Purpose Polystyrene

Americas Styrenics LLC

Message:

STYRON™668 is a general-purpose polystyrene material. This product is available in North America and is processed by injection molding.

STYRON™The main features of the 668 are:

- flame retardant/rated flame
- accessible food
- Good toughness
- Heat resistance

Typical application areas include:

- packing
- food contact applications

General Information			
UL YellowCard	E326906-100171516		
Features	Good liquidity		
	Heat resistance, high		
	Good toughness		
	Compliance of Food Exposure		
Uses	Media packaging		
Agency Ratings	FDA 21 CFR 177.1640		
UL File Number	E326906		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.6	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	3170	MPa	ASTM D638
Tensile Strength			ASTM D638
Fracture, injection molding	50.0	MPa	ASTM D638
Injection Molding	50.0	MPa	ASTM D638
Tensile Elongation (Break, Injection Molded)	3.0	%	ASTM D638
Flexural Modulus (Injection Molded)	3480	MPa	ASTM D790
Flexural Strength (Injection Molded)	66.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact (23°C, Injection Molded)	21	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	94.0	°C	ASTM D648
1.8 MPa, not annealed	86.0	°C	ASTM D648
Vicat Softening Temperature	103	°C	ASTM D1525
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Rear Temperature	218 - 249	°C	
Middle Temperature	218 - 249	°C	
Front Temperature	199 - 213	°C	
Nozzle Temperature	213 - 243	°C	
Mold Temperature	15.6 - 65.6	°C	
Injection Rate	Fast		
Back Pressure	0.200 - 1.20	MPa	
Cushion	6.35	mm	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	177 - 193	°C	
Cylinder Zone 2 Temp.	182 - 204	°C	
Cylinder Zone 3 Temp.	188 - 210	°C	
Cylinder Zone 4 Temp.	199 - 216	°C	
Cylinder Zone 5 Temp.	204 - 221	°C	
Adapter Temperature	193 - 232	°C	
Melt Temperature	193 - 232	°C	
Die Temperature	199 - 232	°C	
Extrusion instructions			

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

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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