

Americas Styrenics EA6740

High Impact Polystyrene

Americas Styrenics LLC

Message:

Americas Styrenics EA6740 is a high impact polystyrene material. This product is available in North America and is processed by extrusion or injection molding.

The main features of the Americas Styrenics EA6740 are:

Impact modification

accessible food

Good toughness

Heat resistance

Typical application areas include:

packing

Consumer goods

food contact applications

General Information			
UL YellowCard	E326906-100264815		
Additive	Rubber impact modifier		
Features	Low Temperature Flexibility		
	Excellent printability		
	Heat resistance, high		
	Compliance of Food Exposure		
Uses	Packaging		
	Toys		
Agency Ratings	FDA 21 CFR 177.1640		
UL File Number	E326906		
Forms	Particle		
Processing Method	Extrusion		
	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)	3.2	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	99		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	1600	MPa	ASTM D638
Tensile Strength			ASTM D638
Fracture, injection molding	19.0	MPa	ASTM D638

Injection Molding	18.0	MPa	ASTM D638
Tensile Elongation (Break, Injection Molded)	75	%	ASTM D638
Flexural Modulus (Injection Molded)	1600	MPa	ASTM D790
Flexural Strength (Injection Molded)	29.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, molded	100	J/m	ASTM D256
23°C, injection molding	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	89.0	°C	ASTM D648
1.8 MPa, not annealed	81.0	°C	ASTM D648
Vicat Softening Temperature	100	°C	ASTM D1525
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
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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