

Transparent Styrenic Copolymer

FEATURES

- **Impact Modified Styrene-Acrylic Copolymer**
- Good gloss
- Competitive against clear ABS and PC
- FDA: 21 CFR 177.1640

APPLICATIONS Injection molding, Toys, Point of purchase (POP), Footwear Compounds

PROPERTIES

	ENGLISH UNITS	TYPICAL VALUES	S.I. UNITS	TYPICAL VALUES	ASTM
PHYSICAL					
Specific Gravity	-	1.05	-	1.05	D792
Melt Flow Rate (G-200°C/5 Kg)	g/10 min	8.0	g/10 min	8.0	D1238
Mold Shrinkage	in/in	4E-03	mm/mm	4E-03	D955
MECHANICAL					
Tensile Strength, Yield	psi	3,200	MPa	22	D638
Yield Elongation	%	2.0	%	2.0	D638
Tensile Strength, Break	psi	2,800	MPa	19	D638
Break Elongation	%	140	%	140	D638
Tensile Modulus	psi	226,000	MPa	1,558	D638
Flexural Strength	psi	4,200	MPa	29	D790
Flexural Modulus	psi	215,000	MPa	1,482	D790
IMPACT RESISTANCE					
Notched Izod Impact (0.125 in)	ft-lb/in	3.0	J/m	160.1	D256
THERMAL					
HDT @ 264 psi (unannealed)	°F	153	°C	67	D648
Vicat Softening Temperature	°F	190	°C	88	D1525
OPTICAL					
Transmittance	%	89	%	89	D1003
Haze	%	1.5	%	1.5	D1003
IGNITION CHARACTERISTICS					
Flammability 0.060 in	-	HB	-	HB	UL 94

.Typical Values represent average laboratory values and are intended as guides only, not as specific specification limits.

.Properties designated in this standard have been determined in accordance with the current issues of the specified testing methods.

.All molded samples were an 1/8 inch (3.2 mm) thick unless noted

Resirene CET-270® is a compound based on styrene-acrylic resins and can be processed under very similar conditions to those of GPPS, with minor differences briefly described below.

AVAILABILITY

Resirene's styrenic resins are available in bulk, 25 kg bags (55 lbs), and 500 - 750 kg boxes (1,100 - 1,652 lbs).

DRYING

This material presents very low moisture absorption and it is a common practice to mold it without pre-drying. However, if the material has been exposed to high moisture environment or direct contact with water, it is recommended to dry it for 1 hour at 140°F (60°C).

MOLD

In order to get the best appearance in molded parts, it is strongly recommended to use highly polished mold, in order to obtain high gloss surfaces. In general, mold control temperature has no effect upon material and finished product clarity.

MOLDING CONDITIONS

Resirene CET-270® is a compound based styrenic; but it has some differences with respect to polystyrene so good purge practices are important. If CET gets contaminated with GPPS or HIPS, such contamination will be reflected as a hazy effect. Contamination with SAN resins will result on delamination because SMMA and SAN are non-compatible.

These conditions may vary from a molding machine to another, but following conditions are suggested for a start-up approach.

	START POINT	RANGE
Melt Temperature	410 °F (210 °C)	392 - 446 °F - (200 - 230 °C)
Mold Temperature	120 °F (49 °C)	100 - 180 °F - (38 - 82 °C)
Maximum Recommended Temperature	464 °F (240 °C)	

WARNING: As most of plastics materials, combustion of this material may cause hazardous fumes and gases, as well as situations that could be dangerous for health, specially in closed places. It should be noted that excessive heating or too long residence times may cause discoloration, degradation or yellowing.

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