

STYRON™ 610

General Purpose Polystyrene

Americas Styrenics LLC

Message:

STYRON™610 is a general-purpose polystyrene material. This product is available in North America and is processed by extrusion or injection molding.

STYRON™The main features of the 610 are:

accessible food

Heat resistance

Typical application areas include:

Movie

Foam

food contact applications

additive/masterbatch

General Information	
UL YellowCard	E326906-100171526
Features	Heat resistance, high
	Compliance of Food Exposure
Uses	Films
	Mixing
	Foam
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)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ASTM D638
Tensile Strength			ASTM D638
Fracture	44.1	MPa	ASTM D638
--	44.1	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	3100	MPa	ASTM D790
Flexural Strength	62.1	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	21	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	96.7	°C	ASTM D648
1.8 MPa, not annealed	88.3	°C	ASTM D648
Vicat Softening Temperature	107	°C	ASTM D1525
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Rear Temperature	213 - 243	°C	
Middle Temperature	218 - 249	°C	
Front Temperature	218 - 249	°C	
Nozzle Temperature	199 - 213	°C	
Mold Temperature	15.6 - 65.6	°C	
Injection Rate	Fast		
Back Pressure	0.200 - 1.20	MPa	
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			

Polish Rolls: 66 - 104 °C Head Pressure: 10 - 21 MPA

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