

Clearblend® 165

Methyl Methacrylate Butadiene Styrene
Styrolution

Message:

CLEARBLEND 165 is an impact modified styrene acrylic copolymer blend with excellent clarity and outstanding toughness.

General Information			
UL YellowCard	E55776-101487295		
Additive	Impact Modifier		
Features	Copolymer		
	Good Processability		
	Good Toughness		
	High Clarity		
	Impact Modified		
	Low Density		
	Low Moisture Absorption		
Uses	Appliances		
	Consumer Applications		
	Housings		
	Industrial Applications		
	Medical/Healthcare Applications		
	Toys		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (200°C/5.0 kg)	5.00	cm³/10min	ISO 1133
Molding Shrinkage			
Flow	0.20 to 0.60	%	ASTM D955
--	0.20 to 0.60	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.10	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	70		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1520	MPa	ASTM D638, ISO 527-2
Tensile Strength			
Yield, 23°C	20.7	MPa	ASTM D638

Yield, 23°C	21.0	MPa	ISO 527-2
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus			
--	1550	MPa	ASTM D790
--	1650	MPa	ISO 178
Flexural Strength			
--	37.2	MPa	ASTM D790
--	37.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	93.9	°C	ASTM D1525 ¹
Maximum Service Temperature	250	°C	
Optical	Nominal Value	Unit	Test Method
Refractive Index ²	1.570		ASTM D542, ISO 489
Transmittance (550 nm)	90.0	%	ASTM D1003
Haze	2.2	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	65.0	°C	
Drying Time	2.0	hr	
Rear Temperature	179 to 213	°C	
Middle Temperature	185 to 218	°C	
Front Temperature	191 to 224	°C	
Processing (Melt) Temp	204 to 238	°C	
Mold Temperature	27.0 to 54.0	°C	
Injection Rate	Moderate-Fast		
NOTE			
1.	Rate B (120°C/h), Loading 1 (10 N)		
2.	Sodium D line		

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