

Americas Styrenics MC3650

General Purpose Polystyrene

Americas Styrenics LLC

Message:

Americas Styrenics MC3650 is a general-purpose polystyrene material. This product is available in North America and is processed by extrusion or injection molding.

The main features of the Americas Styrenics MC3650 are:

- flame retardant/rated flame
- crystal
- accessible food
- Rapid Prototyping Cycle
- Transparency

Typical application areas include:

- kitchen utensils
- home apps
- container
- food contact applications
- medical/health care

General Information			
UL YellowCard	E326906-100264832		
Additive	demoulding		
Features	Crystal		
	Fast molding cycle		
	Definition, high		
	Compliance of Food Exposure		
Uses	Cup		
	Household goods		
	Container		
	Small bottle		
	Disposable tableware		
Agency Ratings	FDA 21 CFR 177.1640		
	USP Class VI		
UL File Number	E326906		
Appearance	Transparent-Light Blue		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm³	ASTM D792

Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	13	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	45.0	MPa	ASTM D638
Injection Molding	45.0	MPa	ASTM D638
Tensile Elongation (Break, Injection Molded)	3.0	%	ASTM D638
Flexural Modulus (Injection Molded)	3310	MPa	ASTM D790
Flexural Strength (Injection Molded)	55.0	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	87.0	°C	ASTM D648
1.8 MPa, not annealed	81.0	°C	ASTM D648
Vicat Softening Temperature	98.0	°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	0.172 - 1.21	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	
Back Pressure	10.3 - 20.7	MPa	

Extrusion instructions

Zone #6: 400 to 430°F Polish Rolls: 150 to 220°F Compression Ratio: 4:1 Extruder Die: 110 - 150% of the required sheet thickness

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