

Network Polymers SAN 280

Styrene Acrylonitrile
Network Polymers, Inc.

Message:

Network Polymers SAN 280 is a Styrene Acrylonitrile (SAN) product. It can be processed by injection molding and is available in North America. Typical application: Food Contact Applications. Primary characteristic: flame rated.

General Information			
Agency Ratings	FDA 21 CFR 181.32(a)(3)(ii)		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹			ASTM D1238
200°C/5.0 kg	4.0	g/10 min	
230°C/3.8 kg	14	g/10 min	
Molding Shrinkage - Flow	0.30 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	63.7	MPa	ASTM D638
Flexural Modulus - Tangent ³	3430	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	87.8	°C	ASTM D648
Vicat Softening Temperature	106	°C	ASTM D1525 ⁴
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Transmittance	90.5	%	ASTM D1003
Haze	1.1	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Shot Size	40 to 75	%	
Rear Temperature	160 to 182	°C	
Middle Temperature	182 to 221	°C	
Front Temperature	193 to 232	°C	
Nozzle Temperature	193 to 232	°C	

Processing (Melt) Temp	193 to 216	°C
Mold Temperature	26.7 to 76.7	°C
Injection Pressure	0.414 to 7.58	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.517 to 1.03	MPa
Clamp Tonnage	2.8 to 4.1	kN/cm ²

NOTE

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| 1. | Procedure A |
| 2. | 51 mm/min |
| 3. | 1.3 mm/min |
| 4. | Loading 1 (10 N) |

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