

POLYMAN® (SAN) 29/10

Styrene Acrylonitrile

A. Schulman Europe

Message:

Good flow SAN grade with high chemical resistance

General Information			
UL YellowCard	E86615-100803164		
Features	Good Chemical Resistance		
	Good Flow		
Processing Method	Injection Molding		
Resin ID (ISO 1043)	SAN		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/3.8 kg)	10.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	171	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3700	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	70.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	%	ISO 527-2/1A/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	17	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	103	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	100	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	106	°C	ISO 306/A50
--	102	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Rear Temperature	180 to 200	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	240 to 250	°C	
Nozzle Temperature	240 to 260	°C	
Processing (Melt) Temp	220 to 250	°C	
Mold Temperature	50.0 to 80.0	°C	

Injection Pressure	100 to 150	MPa
Injection Rate	Moderate-Fast	
Holding Pressure	30.0 to 90.0	MPa
Back Pressure	5.00 to 15.0	MPa
Screw Speed	< 600	mm/sec

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