

STYRON A-TECH™ 1260

High Impact Polystyrene

Americas Styrenics LLC

Message:

STYRON A- TECH™1260 is a high impact polystyrene material. This product is available in North America and is processed by extrusion, thermoforming or injection molding.

STYRON A- TECH™The main features of the 1260 are:

High resistance to environmental stress fracture (ESCR)

accessible food

Good toughness

Impact resistance

Typical application areas include:

packing

container

hat/cap/cork

food contact applications

General Information	
Features	High ESCR (Stress Cracking Resistance)
	Low temperature impact resistance
	Good toughness
	Compliance of Food Exposure
Uses	Packaging
	Cover
	Container
	Food packaging
	Food container
Agency Ratings	FDA 21 CFR 177.1640
UL File Number	E326906
Forms	Particle
Processing Method	Extrusion
	Thermoforming
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	1300	MPa	ASTM D638

Tensile Strength			ASTM D638
Fracture, injection molding	23.0	MPa	ASTM D638
Injection Molding	19.0	MPa	ASTM D638
Tensile Elongation (Break, Injection Molded)	60	%	ASTM D638
Flexural Modulus (Injection Molded)	1600	MPa	ASTM D790
Flexural Strength (Injection Molded)	37.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, Injection Molded)	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	84.0	°C	ASTM D648
1.8 MPa, not annealed	71.0	°C	ASTM D648
Vicat Softening Temperature	104	°C	ASTM D1525
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
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	0.200 - 1.20	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	
Extrusion instructions			
Zone 6 Temperature: 204 to 221°C Melt Pump, Pipes, Screen Changer Temperature: 193 to 232°C Polish Rolls Temperature: 66 to 104°C Head Pressure: 10 to 21 MPa			

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