

STYRON™ 665

General Purpose Polystyrene

Americas Styrenics LLC

Message:

STYRON™665 is a general-purpose polystyrene material. This product is available in North America or Latin America and is processed by extrusion or injection molding. STYRON™The main characteristics of 665 are: contact with food.
Typical application areas include:
Movie
food contact applications

General Information			
Features	Compliance of Food Exposure		
Uses	Films		
Agency Ratings	FDA 21 CFR 177.1640		
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)	1.5	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		

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3170	MPa	ASTM D638
Tensile Strength (Break)	52.0	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	3210	MPa	ASTM D790
Flexural Strength	90.0	MPa	ASTM D790
Tensile Rupture	52.0	MPa	ASTM D638

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	21	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	98.0	°C	ASTM D648
1.8 MPa, not annealed	89.0	°C	ASTM D648
Vicat Softening Temperature	108	°C	ASTM D1525
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696

Injection	Nominal Value	Unit
Rear Temperature	200 - 215	°C

Middle Temperature	215 - 230	°C
Front Temperature	230 - 245	°C
Nozzle Temperature	230 - 245	°C
Back Pressure	0.200 - 1.50	MPa
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		

Polish Rolls: 66 - 104 °C Head Pressure: 10 - 21 MPA

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