



KIBISAN® PN-127

CHI MEI CORPORATION - Styrene Acrylonitrile

Tuesday, November 5, 2019

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• >SAN<		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.06		ASTM D792
Density (73°F)	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (200°C/5.0 kg)	1.5	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	17	cm ³ /10min	ISO 1133
Molding Shrinkage	0.20 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ³ (Yield)	10400	psi	ASTM D638
Tensile Stress (Yield)	10700	psi	ISO 527-2/50
Tensile Stress (Break)	10700	psi	ISO 527-2/50
Tensile Elongation ³ (Break)	5.0	%	ASTM D638
Tensile Strain (Break)	7.0	%	ISO 527-2/50
Flexural Modulus ⁴	510000	psi	ASTM D790
Flexural Modulus ⁵	479000	psi	ISO 178
Flexural Strength ⁴	14900	psi	ASTM D790
Flexural Stress ⁵	15200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	0.95	ft·lb/in ²	ISO 179
Notched Izod Impact			ASTM D256
73°F, 0.126 in	0.37	ft·lb/in	
73°F, 0.252 in	0.33	ft·lb/in	
Notched Izod Impact Strength (73°F)	1.4	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	84		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	198	°F	
Heat Deflection Temperature (264 psi, Unannealed)	194	°F	ISO 75-2/A
Deflection Temperature Under Load (264 psi, Annealed)	214	°F	ASTM D648
Heat Deflection Temperature (264 psi, Annealed)	214	°F	ISO 75-2/A
Vicat Softening Temperature	221	°F	ASTM D1525 ⁶

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	221	°F	ISO 306/A50
--	219	°F	ISO 306/B50
CLTE - Flow	2.0E-5 to 2.1E-5	in/in/°F	ISO 11359-2
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	167 to 176	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	374 to 410	°F
Middle Temperature	392 to 428	°F
Front Temperature	392 to 428	°F
Mold Temperature	104 to 140	°F
Injection Pressure	711 to 996	psi
Holding Pressure	569 to 853	psi
Back Pressure	71.1 to 213	psi

Notes

¹ Typical properties: these are not to be construed as specifications.

² 23°C

³ 0.24 in/min

⁴ 0.11 in/min

⁵ 0.079 in/min

⁶ Rate A (50°C/h), Loading 1 (10 N)