KIBISAN® PN-137H

CHI MEI CORPORATION - Styrene Acrylonitrile

Tuesday, November 5, 2019

General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant	• High Strength	
RoHS Compliance	• RoHS Compliant		
Resin ID (ISO 1043)	• >SAN<		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity [2]	1.06		ASTM D792
Density (73°F)	1.06	g/cm³	ISO 1183
Melt Mass-Flow Rate (200°C/5.0 kg)	0.90	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	12	cm³/10min	ISO 1133
Molding Shrinkage	0.20 to 0.70	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [3] (Yield)	11400	psi	ASTM D638
Tensile Stress (Yield)	12000	psi	ISO 527-2/50
Tensile Stress (Break)	12000	psi	ISO 527-2/50
Tensile Elongation [3] (Break)	7.0	%	ASTM D638
Tensile Strain (Break)	7.0	%	ISO 527-2/50
Flexural Modulus [4]	540000	psi	ASTM D790
Flexural Modulus [5]	580000	psi	ISO 178
Flexural Strength [4]	17000	psi	ASTM D790
Flexural Stress [5]	17800	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	1.4	ft·lb/in²	ISO 179
Notched Izod Impact			ASTM D256
73°F, 0.126 in	0.44	ft·lb/in	
73°F, 0.252 in	0.37	ft·lb/in	
Notched Izod Impact Strength (73°F)	1.4	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (M-Scale)	85		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	196	°F	ISO 75-2/A
Heat Deflection Temperature (264 psi, Annealed)	216	°F	ISO 75-2/A
Vicat Softening Temperature	226	°F	ASTM D1525 [6]
Vicat Softening Temperature			
--	226	°F	ISO 306/A50
--	221	°F	ISO 306/B50
CLTE - Flow	2.0E-5 to 2.1E-5	in/in/°F	ISO 11359-2

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Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			ASTM D648
Annealed	217	°F	
Unannealed	201	°F	
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 185	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	410 to 446	°F
Middle Temperature	428 to 464	°F
Front Temperature	410 to 446	°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)