INEOS STYROLUTION

Zylar 245

Methyl Methacrylate Butadiene Styrene (MBS)

TECHNICAL DATASHEET

DESCRIPTION

Zylar® 245 is a MBS grade that provides practical toughness, good clarity and superior processing characteristics for demanding injection molding applications.

FEATURES

- High clarity
- Practical toughness
- Low density
- Gamma & ETO sterilizable

APPLICATIONS

- Appliance and consumer goods
- Office accessories
- Industrial housings and covers
- Displays
- Toys

Property, Test Condition	Standard	Unit	Values
Rheological Properties			
Melt Volume Rate, 200 °C/5 kg	ISO 1133	cm³/10 min	4.5
Melt Volume Rate 220 °C/10 kg	ISO 1133	cm³/10 min	48
Mechanical Properties			
Izod Notched Impact Strength, 23 °C	ISO 180/A	kJ/m²	2
Izod Unnotched Impact Strength	ISO 180	kJ/m²	16
Charpy Notched Impact Strength, 23° C	ISO 179/1eA	kJ/m²	2
Charpy Unnotched, 23 °C	ISO 179/1eU	kJ/m²	15
Tensile Stress at Yield, 23 °C	ISO 527	MPa	37
Tensile Strain at Break, 23 °C	ISO 527	%	20
Tensile Modulus	ISO 527	MPa	2300
Thermal Properties			
Vicat Softening Temperature VST/B/50 (50N, 50 °C/h)	ISO 306	°C	78
Vicat Softening Temperature, VST/A/120 (10N, 120 °C/h)	ISO 306	°C	102
Heat Deflection Temperature A; (unannealed; 1.8 MPa)	ISO 75	°C	72
Heat Deflection Temperature B; (unannealed; 0.45 MPa)	ISO 75	°C	85
Electrical Properties			

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Property, Test Condition	Standard	Unit	Values
Optical Properties			
Refractive Index, Sodium D Line	ISO 489	-	1.57
Light Transmission at 550 nm	ASTM D 1003	%	90
Haze	ASTM D 1003	%	2
Other Properties			
Density	ISO 1183	kg/m³	1050
Water Absorption, Saturated at 23 °C	ISO 62	%	0.1
Moisture Absorption, Equilibrium 23 °C/50% RH	ISO 62	%	0.05
Processing			
Melt Temperature Range	ISO 294	°C	200 - 240
Mold Temperature Range	ISO 294	°C	30 - 55
Rear Temperature Range	-	°C	180 - 210
Middle Temperature Range	-	°C	185 - 220
Front Temperature Range	-	°C	190 - 225
Drying Temperature	-	°C	65
Drying Time	-	h	2

Typical values for uncolored products

SUPPLY FORM

Zylar resins are available in bulk, 25kg bags or octabin cartons.

PROCESSING

Zylar is a low moisture absorption copolymer and in many instances processes readily without pre-drying. There are combinations of conditions that require the product to be dried, such as high humidity and heavy section molding. Two hours at 60 °C (140 °F) is adequate for most applications. Dehumidifying type driers are recommended. To obtain maximum clarity and gloss from this product, it is necessary to have a highly polished mold. Design of gates, runners and sprues can be patterned after standard practice for high-heat polystyrene. All mold surfaces must be temperature controlled at 54 °C (130 °F) for optimum clarity and surface gloss. For optimum clarity, machine cylinder,barrels, screws, valves, etc. should be thoroughly cleaned before processing. Contamination by other materials will cause streaking or haze.

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