

Technical Data Sheet

Network Polymers San 250

Styrene Acrylonitrile
LyondellBasell Industries
Engineering Plastics

General

- | | |
|-------------------|---------------------|
| Appearance | • Natural Color |
| Processing Method | • Injection Molding |

Physical

	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.07	1.07 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (200°C/5.0 Kg)	0.90 g/10 min	0.90 g/10 min	ASTM D1238

Mechanical

	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	11700 psi	80.7 MPa	ASTM D638
Flexural Modulus	519000 psi	3580 MPa	ASTM D790

Impact

	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.252 In (6.40 Mm)	0.20 ft-lb/in	11 J/m	

Hardness

	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-scale)	122	122	ASTM D785

Thermal

	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed, 0.252 In (6.40 Mm)	196 °F	91.1 °C	

Flammability

	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	160 to 180 °F	71 to 82 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Shot Size	40 to 75 %	40 to 75 %
Rear Temperature	320 to 360 °F	160 to 182 °C
Middle Temperature	360 to 430 °F	182 to 221 °C
Front Temperature	380 to 450 °F	193 to 232 °C
Nozzle Temperature	380 to 450 °F	193 to 232 °C
Processing (Melt) Temp	380 to 420 °F	193 to 216 °C
Mold Temperature	80 to 170 °F	27 to 77 °C
Injection Pressure	60.0 to 1100 psi	0.414 to 7.58 MPa
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa
Clamp Tonnage	2.0 to 3.0 tons/in ²	2.8 to 4.1 kN/cm ²