



STYRON 668 General Purpose Polystyrene Resin

STYRON™ 668 is a general purpose polystyrene with medium flow and a balance of heat resistance and stiffness characteristics that make it suitable for applications such as CD jewel boxes.

- Main Characteristics
- High heat
 - Medium flow
 - High tensile strength
 - Good balance of heat, flow and toughness
 - FDA Compliant ⁽¹⁾

- Applications
- Jewel Box
 - Injection molding

Properties ⁽²⁾	Test Method		S.I.		English		Metric		
	ISO	ASTM	Value	Unit	Value	Unit	Value	Unit	
Physical									
Melt flow rate (200°C / 5 kg)	1133 /8	D 1238	5.3	g/10 min	5.3	g/10 min	5.3	g/10 min	
Specific Gravity	1183	D 792	1.04		1.04		1.04		
Linear Thermal Expansion (10 ⁻⁵)	1135 9	D 696	9.0	cm/cm /°C	5.0	in/in/ °F	9.0	cm/cm /°C	
Mold Shrinkage		D 955	0.003 - 0.007	cm/cm	0.003 - 0.007	in/in	0.003 - 0.007	cm/cm	
Optical									
Transmittance		D 1003	90	%	90	%	90	%	
Haze		D 1003	1	%	1	%	1	%	
Refractive Index		D 542	1.59		1.59		1.59		
Thermal									
Vicat Softening Temperature (120°C/hr, 1 kg)	306A	D 1525- B	105	°C	221	°F	105	°C	
Deflection Temperature Under Load (Injection molded)	75A	D 648							
@ 0.45 MPa (66 psi), Unannealed			89	°C	192	°F	89	°C	
@ 1.8 MPa (264 psi), Unannealed			77	°C	171	°F	77	°C	
Injection Molded Mechanical Properties									
Notched Izod 12.7x3.2 mm (0.5x.125 in) specimen	180/ 4A	D 256							
@ 23°C (73°F)			21.4	J/m	0.4	ft-lb/in	2.2	kg- cm/cm	
Tensile Properties 12.7x3.2 mm (0.5x0.125 in) specimen:									
Yield Tensile Strength mm/min (0.2 in/min) rate	5	527	D 638	51.1	MPa	7400	psi	520	kg/cm ²
Ultimate Tensile Strength mm/min (0.2 in/min) rate	5	527	D 638	51.1	MPa	7400	psi	520	kg/cm ²
Ultimate Elongation mm/min (0.2 in/min) rate	5	527	D 638	2.0	%	2.0	%	2.0	%
Tensile Modulus mm/min (0.2 in/min) rate	5	527	D 638	3136	MPa	454,500	psi	31900	kg/cm ²
Flexural Properties 1.3 mm/min (0.05 in/min) rate									
Flexural Strength (3-point)	178	D 790	102	MPa	14800	psi	1040	kg/cm ²	
Flexural Modulus (3-point)	178	D 790	3540	MPa	513,000	psi	36100	kg/cm ²	



Flammability Properties ⁽³⁾

UL 94 Classification:

@1.5 mm (0.06 in) thickness

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- (1) When used unmodified for the manufacture of food contact articles, STYRON 668 will comply with Food Additive Regulations 21 CFR 177.1640 under the U.S. Food, Drug and Cosmetic Act. Such uses are subject to good manufacturing practices and any other limitations which are part of the statute or regulations. These should be consulted for complete details.
- (2) Typical properties, not to be considered as specification limits.
- (3) This numerical flame-spread rating is not intended to reflect hazards presented by material under actual fire conditions.

Product Stewardship

Americas Styrenics has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our Product Stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our Product Stewardship program rests with each and every individual involved with Americas Styrenics products – from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

Customer Notice

Americas Styrenics strongly encourages its customers to review both their manufacturing processes and their applications of Americas Styrenics products from the standpoint of human health and environmental quality to ensure that Americas Styrenics products are not used in ways for which they are not intended or tested. Americas Styrenics personnel are available to answer your questions and to provide reasonable technical support. Americas Styrenics product literature, including safety data sheets, should be consulted prior to use of Americas Styrenics products. Current safety data sheets are available from Americas Styrenics.

Medical Application Policy

Americas Styrenics will not knowingly sell or sample any product or service (“Product”) into any commercial or developmental application that is intended for:

- a. permanent (long term) contact with internal body fluids or internal body tissues. Long term is a use which exceeds 72 continuous hours
- b. use in cardiac prosthetic devices regardless of the length of time involved (Cardiac prosthetic devices include, but are not limited to, pacemaker leads and devices, artificial hearts, heart valves, intra-aortic balloons and control systems, and ventricular bypass assisted devices);
- c. use as a critical component in medical devices that support or sustain human life; or
- d. use specifically by pregnant women or in applications designed specifically to promote or interfere with human reproduction.

Additionally, all Products intended for use in pharmaceutical applications, other than pharmaceutical packaging, must pass the current Pharmaceutical Liability Guidelines.

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- Authorized distributors and resellers will adhere to this medical policy.
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Additional Information

Headquarters
24 Waterway Avenue
Suite 1200
The Woodlands, TX 77380
Toll Free 888-55-AMSTY (888-552-6789)

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