

SPECIFICATION

STYRENE RESIN COMPOSITION, AND MOLDED ARTICLE THEREOF

TECHNICAL FIELD

[0001] The present invention relates to a sheet for packaging electronic components comprising a styrene resin composition suitable for use in a container for packaging electronic components such as connectors and capacitors.

BACKGROUND ART

[0002] Embossed carrier tapes for mounting electronic components such as IC's and LSI's to electronic devices usually consist of sheets of a thermoplastic resin such as a vinyl chloride resin, a styrene resin or a polycarbonate resin, embossed by thermoforming. Such embossed carrier tapes are often formed of opaque sheets that have been rendered conductive, for example, by adding a conductive filler such as carbon black to a thermoplastic resin, as a countermeasure taken to prevent electrostatic damage to the electronic components. On the other hand, embossed carrier tapes for housing electronic components that are less susceptible to electrostatic damage such as, for example, capacitors, may be of transparent type using thermoplastic resins of relatively high transparency in order to enable the electronic components contained therein to be observed from outside or to detect writing on the components.

[0003] As sheets for use in transparent type embossed carrier tapes, sheets mixing general-purpose polystyrene resins with styrene-conjugated diene block copolymers (see Patent Documents 1 and 2) and sheets using MBS resins (Patent Document 3) have been proposed.

Since the carrier tapes using these sheets are transparent, they enable electronic components contained inside to be viewed from outside, and enable text or the like printed on the components to be sensed, and therefore have come under increased

application in recent years.

RELATED ART

Patent Documents

- [0004] Patent Document 1: JP 2003-055526 A
Patent Document 2: JP 2002-332392 A
Patent Document 3: JP 2003-253069 A

SUMMARY OF THE INVENTION

[0005] However, when these sheets are thermoformed into carrier tapes or the like, if pockets with relatively large draw ratios are to be formed, then they will become very thin at the cavities, making it difficult to obtain cavities of sufficient strength, and the forming may make the sheets less transparent than they were before forming.

[0006] The present invention addresses the problem of providing a styrene resin sheet for use in electronic component packaging such as embossed carrier tape, the sheet enabling pockets of large draw ratio (pocket depth) with excellent transparency and strength to be formed by thermoforming. The present invention further addresses the problem of providing a carrier tape or the like having pockets formed by thermoforming such sheets, enabling writing on the electronic components contained therein to be observed from outside the pockets.

[0007] The present inventors discovered that the aforementioned problems can be solved by thermoforming a sheet comprising three types of styrene resins of different molecular structure, having specific weight-average molecular weights respectively, thereby achieving the present invention.

In other words, the present invention is a sheet for use in electronic component packaging, comprising (A) 29 to 65 parts by mass of a styrene-conjugated diene block copolymer; (B) 51 to 15 parts by mass of a polystyrene resin; and (C) 20 to 9 parts by mass of a high-impact polystyrene resin; wherein the components (A) to (C) have weight-average molecular weights (M_w) in the following ranges:

component (A): $M_w = 80,000$ to $220,000$;

component (B): $M_w = 200,000$ to $400,000$;

component (C): $M_w = 150,000$ to $210,000$.

The resin composition used in the sheet of the present invention should preferably having a melt tension at $220\text{ }^{\circ}\text{C}$ of 10 to 30 mN. Additionally, the proportion of the conjugated diene blocks in 100 parts by mass of component (A) should preferably be 10 to 25 mass%. Furthermore, the peak molecular weight of the styrene blocks of component (A) as measured by GPC should preferably be in the range of 30,000 to 120,000, and the half-width of the molecular weight distribution curve of the styrene blocks should be in the range of 0.8 to 1.25. Finally, the particle size of the graft rubber in component (C) should preferably be 2.2 to $3.0\text{ }\mu\text{m}$, and the proportion of rubber in the graft rubber of the substrate should preferably be 0.75 to 1.90 mass%.

On the other hand, the present invention also includes an embossed carrier tape using the aforementioned sheet.

[0008] According to the present invention, a styrene resin sheet that can be used for electronic component packaging such as embossed carrier tape enabling pockets of large draw ratio (pocket depth) with excellent transparency and strength to be formed by thermoforming is obtained, and the sheet can be thermoformed to obtain a carrier tape enabling writing on electronic components contained therein to be observed from outside the pockets.

BRIEF DESCRIPTION OF THE DRAWINGS

[0009] Fig. 1 shows photographs of the criteria (1-5) for evaluating the formativeness of pockets thermoformed from the sheets of the present invention.

MODES FOR CARRYING OUT THE INVENTION

[0010] The present invention shall be explained in detail below.

As mentioned above, the present invention relates to a sheet comprising a resin composition including (A) a styrene-conjugated diene block copolymer, (B) a polystyrene resin, and (C) a high-impact polystyrene resin, respectively having specific weight-average molecular weights.

[0011] The (A) styrene-conjugated diene block copolymer is a polymer including, in its structure, polymer blocks mainly composed of styrene monomers and polymer blocks

mainly composed of conjugated diene monomers. Examples of styrenic monomers include styrene, o-methylstyrene, p-methylstyrene, p-tert-butylstyrene, 1,3-dimethylstyrene, alpha-methylstyrene, vinylnaphthalene, vinylanthracene and 1,1-diphenylethylene. While the present invention mainly uses styrene, one or more other of the above components may be included as trace components.

[0012] Conjugated diene monomers are compounds having conjugated double bonds in their structure. Examples include 1,3-butadiene (butadiene), 2-methyl-1,3-butadiene (isoprene), 2,3-dimethyl-1,3-butadiene, 1,3-pentadiene, 1,3-hexadiene and 2-methylpentadiene, among which butadiene and isoprene are preferred. One or more types of conjugated diene monomers may be used. The polymer blocks consisting mainly of styrene monomers refer to both polymer blocks consisting of only structures derived from styrene monomers and polymer blocks comprising structures derived from styrene monomers in an amount of at least 50 mass%. The polymer blocks consisting mainly of conjugated diene monomers refer to both polymer blocks consisting of only structures derived from conjugated diene monomers and polymer blocks comprising structures derived from conjugated diene monomers in an amount of at least 50 mass%. The conjugated diene content in the (A) styrene-conjugated diene block copolymer, for every 100 parts by mass of component (A), should preferably be 10 to 25 mass%, 20 to 24 mass%, 20 to 22 mass% or 22 to 24 mass% in view of the mechanical properties of the sheet.

The conjugated diene content refers to the proportion by mass of structures derived from conjugated diene monomers with respect to the entire copolymer. One or more types of styrene-conjugated diene block copolymers may be used. In the present invention, if for example the conjugated diene is butadiene, the styrene-conjugated diene block copolymer may be either a styrene-butadiene (SB) diblock copolymer or a styrene-butadiene-styrene (SBS) triblock copolymer, or may be a resin composed of three or more styrene blocks and two or more butadiene blocks. Furthermore, the copolymer may have a so-called tapered block structure wherein the component ratio between the styrenes and butadienes in the blocks continuously change. Additionally, the styrene-conjugated diene block copolymers may be those that are available on the market used as they are.

[0013] The (A) styrene-conjugated diene block copolymer used in the present

invention, as explained below, has a styrene-converted weight-average molecular weight (Mw) in the range of 80,000 to 220,000. The peak molecular weight of the styrene blocks in component (A) as measured by GPC is preferably in the range of 30,000 to 120,000, more preferably 40,000 to 110,000, or 40,000 to 90,000, or 80,000 to 110,000. Additionally, the molecular weight distribution curve of the styrene blocks in component (A) preferably has a half-width in the range of 0.8 to 1.25, more preferably 1.05 to 1.25, or 0.9 to 1.15, or 1.05 to 1.20. This range ensures that good formability is obtained. The molecular weight distribution curve of the styrene blocks in component (A) can be determined by the following method. First, component (A) is subjected to oxidative degradation by chloroform using osmium tetroxide as a catalyst, in accordance with the method described in I. M. Kolthoff, *et al.*, *J. Polym. Sci.*, I, 429 (1946), then the resulting styrene blocks are dissolved in a tetrahydrofuran solvent and measured by GPC. The molecular weight curve can then be used to determine the styrene-converted peak molecular weight using standard polystyrene (monodisperse). The GPC measurements may be in accordance with conventional techniques, with the main measurement conditions being as follows:

Column temperature:	40 °C
Detection method:	differential refractometry
Mobile phase:	tetrahydrofuran
Sample concentration:	2 mass%
Calibration curve:	from standard polystyrene (monodisperse)

[0014] The half-width can be determined using this molecular weight distribution curve for the styrene blocks. Specifically, when the molecular weight is placed on the horizontal axis using a logarithmic scale with the range of 1000 to 1,000,000 being 15 cm, and the concentration (weight ratio) is placed on the vertical axis at an arbitrary height, the width of the peak on the horizontal axis at a height of 50% of the peak top is the half-width. In this case, the height of the peak top must be that perpendicular to the horizontal axis, and the width of the peak at 50% of the height must be parallel to the horizontal axis. The half-width of the molecular weight distribution curve of the styrene blocks correlates with the molecular weight distribution of the block copolymer. While the method of adjusting the molecular weight distribution is not particularly restricted, when polymerizing the styrene block portions of component (A), block

copolymers of different molecular weights can be obtained by methods such as adjusting the time of addition of the initiator.

[0015] The (B) polystyrene resin is a resin generally known as a GPPS, mainly composed of styrene monomers, but may contain one or more aromatic vinyl compounds such as o-methylstyrene, p-methylstyrene, p-tert-butylstyrene, 1,3-dimethylstyrene, alpha-methylstyrene, vinylanthracene, vinylanthracene and 1,1-diphenylethylene as a trace component, and a commercially available resin may be used.

[0016] The (C) high impact polystyrene resin in the present invention is a resin generally known as a HIPS, and is a polystyrene resin comprising microparticulate graft rubber to which styrene monomers have been grafted. Examples of the rubber components in the graft rubber include, for example, diene rubbers with 1,3-butadiene (butadiene), 2-methyl-1,3-butadiene (isoprene), 2,3-dimethyl-1,3-butadiene, 1,3-pentadiene, 1,3-hexadiene and 2-methylpentadiene as monomers. Additionally, a thermoplastic elastomer which is a styrene-conjugated diene block copolymer wherein the conjugated diene component takes up at least 50 mass% may be used. Among these, polybutadiene and styrene-butadiene block copolymers are preferred.

[0017] With the graft rubber in component (C), having a particle size in the range of at least 2.0 μm and at most 3.0 μm , preferably at least 2.0 μm and at most 2.5 μm , or at least 2.3 μm and at most 2.7 μm , the substrate sheet excels in transparency and strength properties. The graft rubber particle size here refers to the average particle size of the graft rubber component measured by a laser diffraction type particle analyzer. Additionally, in the sheet of the present invention, the graft rubber content derived from component (C) in the sheet when the sheet is defined as 100 mass% should be 0.75 to 1.90 mass%, 0.70 to 1.75 mass%, 0.71 to 1.72 mass%, 0.75 to 1.60 mass% or 0.77 to 1.58 mass% in order to achieve balance between impact resistance and transparency of the sheet. The graft rubber content in component (C) and the proportional content of component (C) in the sheet should preferably be adjusted to put the graft rubber content of the sheet in the above-indicated ranges. The graft rubber content of component (C) can be calculated by dissolving in a mixed solvent of MEK and acetone at a 50/50 mass ratio, recovering the undissolved part in a centrifuge, and finding the mass thereof.

[0018] The sheet of the present invention comprises a resin composition containing 29

to 65 parts by mass, preferably 35 to 60 parts by mass, 35 to 58 parts by mass, or 40 to 55 parts by mass of component (A), 51 to 15 parts by mass, preferably 45 to 20 parts by mass, or 51 to 25 parts by mass of component (B), and 20 to 9 parts by mass of component (C), with (A) to (C) totaling 100 parts by mass. By setting the composition in these ranges, a sheet that is satisfactory in strength properties, impact resistance and transparency can be obtained.

[0019] The weight-average molecular weight (M_w) of each component (A) to (C) can be determined from a standard polystyrene-converted molecular weight distribution curve determined by conventional methods using GPC. As the weight-average molecular weight of the components (A) to (C) of the present invention, resins in the following ranges are used:

Component (A): M_w = 80,000 to 220,000; preferably 140,000 to 200,000; or 150,000 to 200,000; or 140,000 to 150,000.

Component (B): M_w = 200,000 to 400,000; preferably 290,000 to 390,000; or 290,000 to 330,000; or 330,000 to 390,000.

Component (C): M_w = 150,000 to 210,000; preferably 180,000 to 190,000.

By using resins in such ranges of weight-average molecular weight, not only does it become possible to adjust the appropriate range of melt tension for this resin composition as described below, but also a sheet with a good balance of strength properties and transparency can be obtained, with very good formability when thermoforming the resulting sheets into carrier tape or the like, enabling good pocket formation even for deep draw forming. For the purposes of the present invention, good formability means that when forming pockets, the thickness of the pocket side surfaces is enough to achieve good buckling strength for the pockets while simultaneously having good formativeness of the corner portions of the bottom surface of the pockets, so that the mold shape can be faithfully transferred.

If the M_w of components (A) and (B) exceeds the above ranges, then the melt tension can become too high, making the thickness of the pocket side surfaces too thin when press-forming, so that sufficient buckling strength cannot be obtained for the pockets. In the event of compressed-air forming, the formativeness of the corner portions of the bottom surface of the pockets is poor, and the stability when loading electronic components such as IC's is poor. On the other hand, if the M_w of

components (A) and (B) is lower than the above range, then good formability can be obtained for shallow draw press forming, but the side surfaces will become too thick and result in inadequate transparency. Furthermore, deep draw forming of more than a certain level will cause the melt tension to be inadequate, resulting in the formation of holes and preventing products from being formed.

[0020] The melt tension in the present invention is the melt tension measured using a melt tension measuring device with an orifice diameter of 1.0 mm ϕ , an orifice length of 10 mm, and windup speeds of 10, 30 and 50 m/minute. The melt tension at 220 °C of the resin composition comprising components (A) to (C) according to the present invention should preferably be 10 to 30 mN, 13 to 32 mN, 14 to 31 mN, 15 to 29 mN, 16 to 28 mN, 17 to 27 mN, 18 to 26 mN, 19 to 25 mN, 20 to 24 mN, 21 to 23 mN, or 22 to 23 mN. At these ranges, sheets with particularly good formability when thermoforming the sheets into containers can be obtained. When the melt tension is less than 10 mN, holes may form when thermoforming the sheet, and when exceeding 30 mN, the formativeness (sharpness) of the pockets of the formed articles may be deficient. This melt tension can be adjusted within the range of 10 mN to 30 mN by adjusting the weight-average molecular weights of the components (A) to (C) and the proportional content of the components.

[0021] The method of producing the sheet of the present invention using the resin composition comprising the above components (A) to (C) is not particularly limited and the sheet may be produced by a common method. For example, the components (A) to (C) can be blended in a predetermined ratio and mixed using a commonly used mixer such as a tumbler, then kneaded in an extruder to form pellet-shaped compounds. These pellet-shaped compounds can then be extruded using a ϕ 65 mm extruder with a T-die to produce sheets. Additionally, so-called "ear" portions formed during the sheet extrusion process can be pulverized and returned to the substrate layer within a range not greatly affecting the strength of the sheet and the molded article after forming.

[0022] By using publicly known sheet formation methods (thermoforming) such as vacuum forming, compressed-air forming and press-forming, the sheets of the present invention can be used to obtain electronic component packaging containers of free shapes such as carrier tape (embossed carrier tape) and trays. By using the sheets of the present invention, deep draw forming of the container depth of the packaging containers

is possible, and packaging containers of excellent strength can be obtained.

In particular, it is extremely effective in the embossment of carrier tapes.

Embossed carrier tapes are used by placing electronic components in receptacle portions formed by the aforementioned forming methods, then covering with carrier tape and winding into reels to obtain carrier tape bodies which can be used to store and transport electronic components.

- [0023] Carrier tape bodies consist of carrier tape housing electronic components. There are no particular limitations on the type of electronic component to be packaged, but examples include IC's, LED's (light-emitting diodes), resistors and capacitors. Additionally, they can be used to package intermediate products or final products using such electronic components.

EXAMPLES

- [0024] <Methods of Evaluation of Sheets and Formed Articles>

Molded articles produced by forming sheets in accordance with the respective examples/comparative examples and embossing were evaluated in accordance with the below-indicated evaluation methods.

(1) Evaluation of Properties of Raw Material Resin

(1-1) Molecular Weight Measurement

The molecular weight of each resin raw material (A) to (C) used in the present invention was determined as a standard polystyrene-converted weight-average molecular weight (Mw) by a conventional technique using GPC (gel permeation chromatography). The GPC measurements were made under the following conditions:

Column temperature:	40 °C
Method of detection:	differential refractometry
Mobile phase:	tetrahydrofuran
Sample concentration:	2 mass%
Calibration curve:	standard polystyrene (Polymer Laboratories)

- [0025] (1-2) Evaluation of Peak Molecular Weight and Molecular Weight Distribution Peak Width of Styrene Blocks of (A) Styrene-Conjugated Diene Block Copolymer

The (A) component resin and sheets used in the examples and comparative examples were measured for block styrene content after oxidative degradation by

tertiary butyl hydroperoxide using osmium tetroxide as a catalyst (I. M. Kolthoff, *et al.*, *J. Polym. Sci.*, I, 429 (1946)).

The resulting styrene blocks of component (A) were dissolved in a tetrahydrofuran solvent, and chromatographs of the molecular weight distribution were obtained by a conventional technique using gel permeation chromatography (GPC). The peak molecular weight was determined by performing GPC measurements of the GPC standard polystyrene (monodisperse), and reading the peak molecular weight from the measured chromatograph based on the calibration curve for the number-average molecular weight of the standard polystyrene and the peak count.

The molecular weight distribution chart from which the above peak molecular weight was determined was arranged with the molecular weight shown on the horizontal axis with a logarithmic scale, with the range of 1000 to 1,000,000 being 15 cm, and the width of the peak (in units of cm) on the horizontal axis was determined at 50% of the height of the peak top.

[0026] (2) Sheet Formability Evaluation

Using sheets according to the respective examples and comparative examples, pockets of depth 9 mm and 18 mm were formed in press forming apparatus and compressed-air forming apparatus, and the formativeness thereof was evaluated by the “sharpness” of the molded article. Additionally, the press-forming was evaluated by whether or not holes were opened in the pockets during forming, and for those without holes, the thickness of the side surface of the pockets.

(Forming Conditions)

Press forming: heater temperature 190 °C

Compressed-air forming: heater temperature 220 °C

(Formativeness Evaluation Criteria)

The pocket angles of the molded articles were observed, and the “sharpness” was graded in five levels by visual observation in accordance with the samples 1-5 shown in Fig 1.

[0027] (3) Molded Article Transparency Evaluation

The bottom surfaces and side surfaces of pockets of the molded articles obtained by molding in the press forming apparatus were all cut out, held between black plates with holes of ϕ 6 mm (28.26 mm²), and the haze values of the bottom surfaces and side

surfaces were measured by a haze meter in accordance with JIS K 7105.

(4) Molded Article Buckle Strength Evaluation

A strograph (Toyo Seiki) was used to measure, as the buckle strength, the strength needed to compress the pocket bottom portion to 4 mm (pocket depth 9 mm) and 8 mm (pocket depth 18 mm) when placing a molded article obtained by forming with a press forming apparatus with the pocket mouth portion down. The buckle strength is considered to be sufficient to withstand actual use as a container with a value of at least 35 N in a molded article of depth 9 mm and at least 30 N in a molded article of pocket depth 18 mm.

[0028] <Resins Used in Examples and Comparative Examples>

The properties of the resin components (A) to (C) used in the examples and comparative examples of the present invention are shown in Table 1.

(Example 1)

58 parts by mass of a styrene-butadiene block copolymer (Mw: 150,000; conjugated diene content 20 mass%) (A-1), 33 parts by mass of a polystyrene resin (Mw: 330,000) (B-1) and 9 parts by mass of a high impact polystyrene resin (Mw: 180,000; graft rubber particle size 2.5 μm) (C-1) were dry-blended, and formed into a film using a ϕ 40 mm extruder (L/D = 26) and a T-die of width 600 mm, to form a sheet of thickness 500 μm .

The rubber part of the graft rubber in the resulting sheet was 0.77 mass% (calculated value) with respect to 100 mass% of the resin composition. The results of evaluation tests of this sheet are shown in Table 2, Table 3 and Table 4.

[0029] (Examples 2-14, Comparative Examples 1-12)

Sheets were obtained in the same manner as Example 1 aside from using resins chosen from A-1 to A-5, B-1 to B-5 and C-1 to C-3 shown in Table 1 as the resin components (A) to (C), and blending them in the mass ratios shown in Table 2.

[0030] Evaluation results for molded articles of pocket depth 9 mm and 18 mm for the respective examples are shown in Table 3 and Table 4 respectively.

[0031] [Table 1]

		Weight Average Molecular Weight	Conjugated Diene Content (Mass%)	Styrene Block Peak Molecular Weight	Styrene Block Peak Half-width (cm)
Styrene-Butadiene Copolymer (A)	A-1	150,000	20	40,000	1.11
	A-2	140,000	24	109,000	0.94
	A-3	200,000	22	85,000	1.07
	A-4	240,000	12	130,000	0.80
	A-5	70,000	40	15,000	1.30

		Weight Average Molecular Weight
Polystyrene (B)	B-1	330,000
	B-2	290,000
	B-3	390,000
	B-4	470,000
	B-5	120,000

		Weight Average Molecular Weight	Graft Rubber Particle Size (μm)	Graft Rubber Content (mass%)
High-Impact Polystyrene (C)	C-1	180,000	2.5	8.6
	C-2	190,000	2.0	7.9
	C-3	100,000	1.8	6.1

[0032]

[Table 2]

	Styrene-Conjugated Diene Block Copolymer (A)						Polystyrene (B)						High Impact Polystyrene (C)			Graft Rbbr Content (mass%)	Melt Tensn (10 m/min) (mN)	Melt Tensn (30 m/min) (mM)	Melt Tensn (50 m/min) (mN)
	A1	A2	A3	A4	A5		B1	B2	B3	B4	B5		C1	C2	C3				
Example 1	58						33						9			0.77	18	20	21
Example 2		58					33							9		0.71	18	20	21
Example 3	58							33					9			0.77	16	19	20
Example 4	40						51						9			0.77	26	30	31
Example 5		40						51						9		0.71	23	27	28
Example 6		58						33					9			0.77	17	19	20
Example 7	55						25						20			1.72	16	18	19
Example 8		55					25							20		1.58	15	17	18
Example 9	55							25					20			1.72	14	17	18
Example 10	35						45						20			1.72	22	26	27
Example 11		35						45						20		1.58	20	23	24
Example 12		55						25						20		1.58	15	17	18
Example 13			58						33				9			0.71	29	31	32
Example 14	65						15						20			1.72	13	15	17
Comp. Example 1				58						33					9	0.55	31	33	34
Comp. Example 2				40						51					9	0.55	33	35	36
Comp. Example 3					40						51				9	0.55	8	9	9
Comp. Example 4					58						33				9	0.55	7	8	8
Comp. Example 5				55						25					20	1.22	30	32	33
Comp. Example 6				35						45					20	1.22	31	33	34
Comp. Example 7					35						45				20	1.22	9	10	10
Comp. Example 8					55						25				20	1.22	8	9	10
Comp. Example 9	80						11						9			0.71	15	17	17
Comp. Example 10	30						61						9			0.71	31	34	35
Comp. Example 11		50						20						30		2.37	16	18	20
Comp. Example 12	75						20						5			0.43	14	16	17

[0033] [Table 3]

	Press Forming						Comp Air Forming
	Formative ness	Holes	Side Thickness (μm)	Haze (Bottom) (%)	Haze (Side) (%)	Buckle Strength (N)	Formative ness
Example 1	5	none	225	15	12	60	5
Example 2	5	none	225	14	12	60	5
Example 3	5	none	253	13	12	68	5
Example 4	5	none	171	12	11	46	5
Example 5	5	none	191	12	11	51	5
Example 6	5	none	238	12	12	64	5
Example 7	5	none	247	17	14	66	5
Example 8	5	none	266	16	14	71	5
Example 9	5	none	272	15	15	74	5
Example 10	5	none	184	14	13	49	5
Example 11	5	none	203	14	13	54	5
Example 12	5	none	270	14	15	72	5
Example 13	5	none	150	13	11	40	5
Example 14	5	none	285	14	15	38	5
Comp. Example 1	5	none	128	15	10	33	2
Comp. Example 2	5	none	123	15	10	32	1
Comp. Example 3	5	none	331	15	25	88	5
Comp. Example 4	5	none	335	15	25	89	5
Comp. Example 5	5	none	128	17	13	33	2
Comp. Example 6	5	none	127	17	13	33	1
Comp. Example 7	5	none	326	17	27	87	5
Comp. Example 8	5	none	330	17	28	88	5
Comp. Example 9	5	none	265	17	13	33	5
Comp. Example 10	5	none	127	16	10	27	5
Comp. Example 11	5	none	255	27	28	50	5
Comp. Example 12	5	none	279	11	11	32	5

[0034] [Table 4]

	Press Forming						Comp Air Forming
	Formative ness	Holes	Side Thickness (μm)	Haze (Bottom) (%)	Haze (Side) (%)	Buckle Strength (N)	Formative ness
Example 1	5	none	150	15	11	40	5
Example 2	5	none	150	14	11	40	5
Example 3	5	none	169	13	11	45	5
Example 4	5	none	120	12	10	36	5
Example 5	5	none	117	12	10	35	5
Example 6	5	none	159	12	11	42	5
Example 7	5	none	169	17	14	45	5
Example 8	5	none	180	16	14	48	5
Example 9	5	none	193	15	15	51	5
Example 10	5	none	123	14	14	33	5
Example 11	5	none	135	14	13	36	5
Example 12	5	none	180	14	14	48	5
Example 13	5	none	105	14	10	33	4
Example 14	5	none	208	16	14	37	5
Comp. Example 1	5	none	95	15	9	25	2
Comp. Example 2	5	none	90	15	9	24	1
Comp. Example 3	1	yes	-	-	-	-	5
Comp. Example 4	1	yes	-	-	-	-	5
Comp. Example 5	5	none	98	17	12	26	2
Comp. Example 6	5	none	94	17	12	25	2
Comp. Example 7	1	yes	-	-	-	-	5
Comp. Example 8	1	yes	-	-	-	-	5
Comp. Example 9	4	none	180	15	11	28	5
Comp. Example 10	4	none	96	14	9	24	4
Comp. Example 11	5	none	168	23	19	31	5
Comp. Example 12	4	none	199	9	9	21	5

* The “-” symbol in the table indicates that no evaluation was made due to the presence of holes.

CLAIMS

- [1] A sheet for use in electronic component packaging, comprising (A) 29 to 65 parts by mass of a styrene-conjugated diene block copolymer; (B) 51 to 15 parts by mass of a polystyrene resin; and (C) 20 to 9 parts by mass of a high-impact polystyrene resin; wherein the components (A) to (C) have weight-average molecular weights (M_w) in the following ranges:
- component (A): $M_w = 80,000$ to $220,000$;
component (B): $M_w = 200,000$ to $400,000$;
component (C): $M_w = 150,000$ to $210,000$.
- [2] The sheet for use in electronic component packaging according to claim 1, having a melt tension at $200\text{ }^{\circ}\text{C}$ of 10 to 30 mN.
- [3] The sheet for use in electronic component packaging according to claim 1 or claim 2, wherein the proportion of the conjugated diene blocks in 100 mass% of component (A) is 10 to 25 mass%.
- [4] The sheet for use in electronic component packaging according to any one of claims 1 to 3, wherein the peak molecular weight of the styrene blocks of component (A) as measured by GPC is in the range of 30,000 to 120,000, and the half-width of the molecular weight distribution curve of the styrene blocks is in the range of 0.8 to 1.25.
- [5] The sheet for use in electronic component packaging according to any one of claims 1 to 4, wherein the particle size of the graft rubber in component (C) is 2.0 to 3.0 μm , and the proportion of rubber in the graft rubber of the substrate is 0.75 to 1.90 mass%.
- [6] An embossed carrier tape using the sheet according to any one of claims 1 to 5.