IDEMITSU PS NC770

TECHNICAL DATA SHEET

High Impact Polystyrene

Effective date: 1st July 2021

PROPERTIES	TESTING METHOD	UNITS	RANGE
Melt Flow Rate (200°C/5 kg)	ISO 1133	g/10 min	1 ~ 17
Heat Deflection Temperature	ISO 75	°C	≥ 65
Tensile Strength (Yield)	ISO 527-1	MPa	≥ 15
Charpy Impact Strength (Notched)	ISO 179	kJ/m^2	≥ 5

Notes:

i) The properties of resin summarized in this brochure are typical, or average properties measured intended as guides only, not as specification limits.

ii) Any description, data and etc given herein may change without prior information and do not constitute the agreed contractual quality of the product.

iii) This product has wide range (variation) of properties and the suitable usage depends on each lot's properties by Certificate of Analysis (COA). It has to be judged by user for use.

PACKAGING

The standard product is available in PP woven laminated paper bag Both ends of the reinforced woven polypropylene bag are sealed with sewn craft tape. When handling or lifting the product, avoid pulling the tape area as this may break the seam and resulting spill. The product is also available in various packing pattern such as jumbo packing and sea bulk.

STORAGE AND HANDLING

Keep dry and cool as possible. Prevent direct exposure to sunlight. The Internal warehouse Conditions for Storage (Malaysia):

Temperature - ≤ 40°C, Shaded

PRE-DRYING

Polystyrene has less moisture absorption that basically pre drying is unnecessary. However pellets can hold surface moisture. When condensation occurred or its application required excellent surface appearance, it should be dried prior moulding. Recommended drying condition are 1~2 hours at 70°C with hot air dryer. DO NOT dry in excess duration to avoid disoloration and properties deterioration may result.

PROCESS GUIDELINE

– INJECTION APPLICATION

PARAMETERS		UNITS	VALUES
CYLINDER TEMPERATURE	REAR	°C	180 ~ 210
	MIDDLE	°C	190 ~ 220
	FRONT	°C	210 ~ 240
	NOZZLE	°C	200 ~ 230
MOULD TEMPERATURE		°C	40 ~ 60

– EXTRUSION APPLICATION

PARAMETERS		UNITS	VALUES
CYLINDER TEMPERATURE	ZONE 1	°C	160 ~ 200
	ZONE 2	°C	180 ~ 220
	ZONE 3	°C	200 ~ 240
	ZONE 4	°C	200 ~ 240
DIE TEMPERATURE		°C	190 ~ 220

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