

Synthos PS HI 336M

High Impact Polystyrene

Synthos S.A.

Message:

SYNTHOS PS HI 336M is high-impact polystyrene (HIPS) with very easy flow - good processability. It is a thermoplastic material designed for injection moulding.

Product has a form of lens granules of diameter 2,5 to 4 mms.

APPLICATION

Injection moulding is used to produce thin-walled and shape-consuming products with the possibility of achieving high performance in processing e.g. cups, parts of boxes in the refrigerator.

The composition of the polymer meets the requirements of the Health and can therefore be used for the production of articles coming into contact with food.

General Information			
Features	Food Contact Acceptable		
	Good Processability		
	High Flow		
	High Impact Resistance		
Uses	Cups		
	Thin-walled Parts		
Appearance	Opaque		
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	11 to 13	g/10 min	ISO 1133
Molding Shrinkage	0.30 to 0.60	%	Internal Method
Particle Size	2.50 to 4.00	mm	
Residual Styrene	0.025	%	Internal Method
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	70	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	82.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature			
Desiccant Dryer	70.0	°C	
Hot Air Dryer	70.0	°C	
Drying Time			

Desiccant Dryer	1.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Processing (Melt) Temp	180 to 260	°C
Mold Temperature	10.0 to 60.0	°C
Extrusion	Nominal Value	Unit
Melt Temperature	200 to 240	°C

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