

Kumho PS HI 425EP

High Impact Polystyrene

Korea Kumho Petrochemical Co., Ltd.

Message:

Features: ESCR, Deep draw thermoforming

Applications: Door liner, Refrigerator inner liner

General Information			
Features	Good stripping		
Uses	Household goods		
RoHS Compliance	RoHS compliance		
UL File Number	E654224		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.2	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.60	%	ASTM D955
Water Absorption (Equilibrium)	0.030	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	50		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	23.0	MPa	ASTM D638
Tensile Elongation (Yield)	60	%	ASTM D638
Flexural Modulus	1520	MPa	ASTM D790
Flexural Strength (Yield)	30.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	79.0	°C	ASTM D648
Vicat Softening Temperature	98.0	°C	ASTM D1525 ¹
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	60.0 - 70.0	°C	
Drying Time	1.0 - 3.0	hr	
Rear Temperature	170 - 190	°C	
Middle Temperature	180 - 200	°C	
Front Temperature	190 - 210	°C	
Nozzle Temperature	190 - 220	°C	
Mold Temperature	40.0 - 60.0	°C	
Injection instructions			

Injection Hopper Throat: 45 °C

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	170 - 190	°C
Cylinder Zone 2 Temp.	180 - 200	°C
Cylinder Zone 3 Temp.	180 - 210	°C
Cylinder Zone 4 Temp.	190 - 220	°C
Cylinder Zone 5 Temp.	200 - 220	°C
Adapter Temperature	200	°C
Die Temperature	190 - 210	°C

Extrusion instructions

Extrusion Screen Changer: 190 to 210 °C

NOTE

1. 速率 A (50°C/h), 压力1 (10N)

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