

DOKI® PS 680L

General Purpose Polystyrene

DIOKI d.d.

Message:

DOKI® POLISTIREN 680 L is transparent general purpose polystyrene exhibiting good melt flow properties.
DOKI® POLISTIREN 680 L is basically intended for extrusion, foam extrusion, and injection moulding of thick-walled moulded products.
DOKI® POLISTIREN 680 L is characterized by good thermal and dimensional stability of moulded products.

General Information			
Features	Food Contact Acceptable		
	Good Dimensional Stability		
	Good Flow		
	Good Thermal Stability		
Uses	Blending		
	Cosmetic Packaging		
	Pharmaceutical Packaging		
	Reinforced Panels		
	Thick-walled Parts		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/72/EC		
	EU 2004/19/EC		
	EU 94/62/EC		
Appearance	Clear/Transparent		
Forms	Pellets		
Processing Method	Extrusion		
	Foam Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Apparent Density	0.60	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (230°C/1.2 kg)	4.0	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2
Tensile Stress			ISO 527-2

Yield	40.0	MPa	
Break	40.0	MPa	
Tensile Strain (Break)	1.0	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	< 1.0	kJ/m ²	ISO 180/4A
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	98.0	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Processing (Melt) Temp	180 to 230	°C	
Mold Temperature	20.0 to 60.0	°C	
Extrusion	Nominal Value	Unit	
Melt Temperature	180 to 230	°C	

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