

Styrolution PS 476L

High Impact Polystyrene (HIPS)

TECHNICAL
DATASHEET

DESCRIPTION

Styrolution PS 476L is a normal flow and very high impact Polystyrene. It gives good mechanical and heat resistance properties while providing with easy processability and short cycle time.

FEATURES

- Normal flow HIPS
- Good mechanical and heat resistance properties
- Easy processability with short cycle time

APPLICATIONS

- Wide range of injection molding applications , e.g. - office, kitchen and bathroom articles;
- Food packaging as beverage cups, packaging for dairy products, sheets and disposables
- Internal parts and housings of household appliances and consumer electronics
- Toys

Property, Test Condition	Standard	Unit	Values
Rheological Properties			
Melt Volume Rate, 200 °C/5 kg	ISO 1133	cm ³ /10 min	5.5
Mechanical Properties			
Izod Notched Impact Strength, 23 °C	ISO 180/A	kJ/m ²	11
Charpy Notched Impact Strength, 23° C	ISO 179/1eA	kJ/m ²	15
Charpy Unnotched, 23 °C	ISO 179/1eU	kJ/m ²	N
Charpy Unnotched, -30 °C	ISO 179/1eU	kJ/m ²	130
Tensile Stress at Yield, 23 °C	ISO 527	MPa	27
Tensile Strain at Yield, 23 °C	ISO 527	%	1.5
Tensile Strain at Break, 23 °C	ISO 527	%	30
Tensile Modulus	ISO 527	MPa	1850
Elongation at Break (MD)	ISO 527	%	-
Flexural Strength, 23 °C	ISO 178	MPa	40
Flexural Modulus, 23 °C	ISO 178	MPa	1950
Hardness, Ball Indentation	ISO 2039-1	MPa	85
Thermal Properties			

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Property, Test Condition	Standard	Unit	Values
Vicat Softening Temperature VST/B/50 (50N, 50 °C/h)	ISO 306	°C	90
Vicat Softening Temperature, VST/A/50 (10N, 50 °C/h)	ISO 306	°C	98
Heat Deflection Temperature A; (annealed 4 h/80 °C; 1.8 MPa)	ISO 75	°C	80
Heat Deflection Temperature B; (annealed 4 h/80 °C; 0.45 MPa)	ISO 75	°C	89
Coefficient of Linear Thermal Expansion	ISO 11359	10 ⁻⁶ /°C	100
Electrical Properties			
Dielectric Constant (100 Hz)	IEC 60250	-	2.5
Dissipation Factor (1 MHz)	IEC 60250	10 ⁻⁴	4
Dielectric Strength, Short Time, 1.5 mm	IEC 60243-1	kV/mm	155
Relative Permittivity (100 Hz)	IEC 60250	-	2.5
Relative Permittivity (1 MHz)	IEC 60250	-	2.5
Volume Resistivity	IEC 60093	Ohm*m	>1E16
Surface Resistivity	IEC 60093	Ohm	>1E13
Optical Properties			
Specular Gloss, 60 °	ASTM D 523	%	35
Other Properties			
Density	ISO 1183	kg/m ³	1050
Water Absorption, Saturated at 23 °C	ISO 62	%	<0.1
Moisture Absorption, Equilibrium 23 °C/50% RH	ISO 62	%	<0.1
Processing			
Linear Mold Shrinkage	ISO 294-4	%	0.4 - 0.7
Melt Temperature Range	ISO 294	°C	180 - 260
Mold Temperature Range	ISO 294	°C	10 - 60
Injection Velocity	ISO 294	mm/s	200

Typical values for uncolored products

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SUPPLY FORM

Styrolution PS 476 L is supplied as cylindrical shaped granules. It has to be kept in its original containers in a dry, cool place. Avoid direct exposure to sunlight. Styrolution PS 476 L can also be stored in silos.

PROCESSING

Styrolution PS 476L can be processed by any method applicable to polystyrene based plastics, it is best suitable for injection molding and extrusion molding. Recommended processing at temperatures between 180 and 280°C and mold temperatures are between 10 and 60°C. The melt temperature should not exceed 240 °C.

PRODUCT SAFETY

During processing of Styrolution PS resins small quantities of styrene monomer may be released into the atmosphere. At styrene vapor concentrations below 20 ppm no negative effects on health are expected. In our experience, the concentration of styrene does not exceed 1 ppm in well ventilated workplaces - that is where five to eight air changes per hour are made. Further information can be found in our Styrolution PS safety data sheets.

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