



IDEMITSU PS

PROCESSING INFORMATION

Injection Moulding & Extrusion Parameters

INJECTION MOULDING CONDITIONS FOR PS

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
DRYING*	TEMPERATURE	°C	70
	TIME	HOURS	1~2

Note :

- * PS has less moisture absorption that basically pre drying is unnecessary. However, pre drying is found to be assistance in parts where a high quality surface finish is required. Flame retardant PS may require more than 2 hours drying time at the same above drying temperature.

EXTRUSION MOULDING CONDITIONS FOR PS

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
DRYING*	TEMPERATURE	°C	70
	TIME	HOURS	1~2

Note :

- * PS has less moisture absorption that basically pre drying is unnecessary. However, pre drying is found to be assistance in parts where a high quality surface finish is required. Flame retardant PS may require more than 2 hours drying time at the same above drying temperature.

Disclaimer:

The parameter values are to be considered as general guideline or a starting point. Users shall determine their machine parameters and bear full responsibility of the final settings and any changes of parameters.



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