

# Idemitsu PS HT54

General Purpose Polystyrene

Idemitsu PS

Message:

Idemitsu PS HT54 is a General Purpose Polystyrene product. It can be processed by extrusion or injection molding and is available in Asia Pacific. Characteristics include:  
Flame Rated  
High Gloss

General Information			
Features	High Gloss		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.4	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	33.0	MPa	ISO 527-2
Tensile Strain (Break)	58	%	ISO 527-2
Flexural Modulus	2050	MPa	ISO 178
Flexural Stress	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	14	kJ/m <sup>2</sup>	ISO 179
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	96.0	°C	ISO 306
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	70.0	°C	
Drying Time	1.0 to 2.0	hr	
Rear Temperature	180 to 210	°C	
Middle Temperature	190 to 220	°C	
Front Temperature	210 to 240	°C	
Nozzle Temperature	200 to 230	°C	
Mold Temperature	40.0 to 60.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	70.0	°C	
Drying Time	1.0 to 2.0	hr	
Cylinder Zone 1 Temp.	160 to 200	°C	
Cylinder Zone 2 Temp.	180 to 220	°C	

Cylinder Zone 3 Temp.	200 to 240	°C
Cylinder Zone 4 Temp.	200 to 240	°C
Die Temperature	190 to 220	°C

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