

DOKI® PS 472

High Impact Polystyrene

DIOKI d.d.

Message:

DOKI® POLISTIREN 472 is elastomer modified high impact polystyrene specially developed for processing by extrusion and thermoforming. It exhibits excellent extrudability and tensile strength.

DOKI® POLISTIREN 472 is miscible with other DOKI polystyrene grades, but it is not miscible with ABS or SAN plastomers.

General Information	
Features	Disposable
	Food Contact Acceptable
	High Impact Resistance
	High Tensile Strength
Uses	Blending
	Containers
	Packaging
	Thermoformed Containers
	Thick-walled Parts
Agency Ratings	EC 1907/2006 (REACH)
	EU 2002/72/EC
	EU 2004/19/EC
	EU 94/62/EC
Forms	Pellets
Processing Method	Extrusion
	Thermoforming

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)	3.5	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	55		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1800	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	18.0	MPa	
Break	21.0	MPa	

Tensile Strain (Break)	> 35	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	11	kJ/m ²	ISO 180/4A
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	87.0	°C	ISO 306/B50
Extrusion	Nominal Value	Unit	
Melt Temperature	160 to 230	°C	
Die Temperature	20.0 to 60.0	°C	

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