

API PS 650-21

High Impact Polystyrene
American Polymers, Inc.

Message:

API 650-21 has been developed for injection molding applications that need a high degree of toughness and gloss than conventional polystyrene. This polymer approaches ABS type properties.
Application: Widely used in appliance housings, toys, bathroom accessories, and displays

General Information			
Features	Good Impact Resistance		
	Good Toughness		
	High Gloss		
Uses	Appliance Components		
	Bathroom Accessories		
	Decorative Displays		
	Electrical Housing		
	Toys		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	8.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (L-Scale)	45		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1990	MPa	ASTM D638
Tensile Strength (Break)	21.4	MPa	ASTM D638
Tensile Elongation (Break)	48	%	ASTM D638
Flexural Modulus	2000	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm, Injection Molded)	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	81.1	°C	ASTM D648
Vicat Softening Temperature	88.9	°C	ASTM D1525
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Drying Time	2.0	hr	

Suggested Max Regrind	30	%
Rear Temperature	177 to 232	°C
Front Temperature	191 to 274	°C
Mold Temperature	-6.67 to 71.1	°C
Injection Pressure	34.5 to 276	MPa
Back Pressure	0.0689 to 3.45	MPa

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