

# DOKI® PS 678E

General Purpose Polystyrene

DIOKI d.d.

Message:

DOKI® POLISTIREN 678 E is transparent general purpose polystyrene exhibiting excellent optical properties. Owing to its high melt flow rate, DOKI® POLISTIREN 678 E is especially intended for injection moulding of thin-walled products having good optical properties. DOKI® POLISTIREN 678 E exhibits excellent processability with short processing cycles.

| General Information                      |                          |          |             |
|--|--------------------------|----------|-------------|
| Features                                 | Fast Molding Cycle       |          |             |
|  | Food Contact Acceptable  |          |             |
|  | Good Processability      |          |             |
|  | High Flow                |          |             |
|  | Opticals                 |          |             |
| Uses                                     | Cosmetic Packaging       |          |             |
|  | General Purpose          |          |             |
|  | Optical Data Storage     |          |             |
|  | Pharmaceutical Packaging |          |             |
|  | Thin-walled Parts        |          |             |
|  | Toys                     |          |             |
| Agency Ratings                           | EC 1907/2006 (REACH)     |          |             |
|  | EU 2002/72/EC            |          |             |
|  | EU 2004/19/EC            |          |             |
|  | EU 94/62/EC              |          |             |
| Appearance                               | Clear/Transparent        |          |             |
| Forms                                    | Pellets                  |          |             |
| Processing Method                        | Injection Molding        |          |             |
| Physical                                 | Nominal Value            | Unit     | Test Method |
| Density                                  | 1.05                     | g/cm³    | ISO 1183    |
| Apparent Density                         | 0.60                     | g/cm³    | ISO 60      |
| Melt Mass-Flow Rate (MFR) (230°C/1.2 kg) | 11                       | g/10 min | ISO 1133    |
| Molding Shrinkage                        | 0.40 to 0.60             | %        |             |
| Hardness                                 | Nominal Value            | Unit     | Test Method |
| Rockwell Hardness (R-Scale)              | 105                      |          | ISO 2039-2  |
| Mechanical                               | Nominal Value            | Unit     | Test Method |
| Tensile Modulus                          | 3300                     | MPa      | ISO 527-2   |
| Tensile Stress                           |                          |          | ISO 527-2   |
| Yield                                    | 43.0                     | MPa      |             |

|                              |               |                   |             |
|------------------------------|---------------|-------------------|-------------|
| Break                        | 43.0          | MPa               |             |
| Tensile Strain (Break)       | 1.0           | %                 | ISO 527-2   |
| Impact                       | Nominal Value | Unit              | Test Method |
| Notched Izod Impact Strength | < 1.0         | kJ/m <sup>2</sup> | ISO 180/4A  |
| Thermal                      | Nominal Value | Unit              | Test Method |
| Vicat Softening Temperature  | 85.0          | °C                | ISO 306/B50 |
| Injection                    | Nominal Value | Unit              |             |
| Processing (Melt) Temp       | 160 to 230    | °C                |             |
| Mold Temperature             | 20.0 to 60.0  | °C                |             |

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