

LG PS 60HRI

High Impact Polystyrene

LG Chem Ltd.

Message:

LG PS 60HRI is a High Impact Polystyrene material. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding.

Important attributes of LG PS 60HRI are:

Flame Rated

Impact Modified

Typical application of LG PS 60HRI: Appliances

General Information	
UL YellowCard	E67171-248518
Additive	Impact Modifier
Features	General Purpose
	Impact Modified
Uses	Appliance Components
Processing Method	Injection Molding
Multi-Point Data	Specific Heat vs. Temperature (ISO 11403-2)
	Viscosity vs. Shear Rate (ISO 11403-2)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	6.0	g/10 min	
220°C/10.0 kg	65	g/10 min	
230°C/3.8 kg	15	g/10 min	

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	99		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	1780	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	26.5	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield, 3.20 mm	5.0	%	
Break, 3.20 mm	62	%	

Flexural Modulus ⁴ (3.20 mm)	2130	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	42.2	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	59	J/m	
-30°C, 6.40 mm	49	J/m	

23°C, 3.20 mm	130	J/m	
23°C, 6.40 mm	88	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	91.0	°C	
1.8 MPa, Unannealed, 6.40 mm	82.0	°C	
Vicat Softening Temperature	90.0	°C	ASTM D1525 ⁶
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.60 mm	HB		
3.20 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Minimum Moisture Content	0.010	%	
Rear Temperature	170 to 190	°C	
Middle Temperature	180 to 200	°C	
Front Temperature	190 to 210	°C	
Nozzle Temperature	190 to 220	°C	
Processing (Melt) Temp	190 to 220	°C	
Mold Temperature	40.0 to 70.0	°C	
Back Pressure	29.4 to 58.8	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	1.0 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	15 mm/min		
5.	15 mm/min		
6.	Rate A (50°C/h), Loading 2 (50 N)		

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