



MATERIAL DATASHEET

TPSC Asia Polystyrene 1540

High Flow Polystyrene

UL File Number: E472299

Polystyrene Crystal 1540 is a high flow polystyrene for injection molding application. It offers low viscosity at high shear rate, that allows a good injectability, and a relatively high softening point.

Applications:

- Cutlery
- Jewel Box
- Toy

Properties	Test Method		S.I.		Metric		English	
	ISO	ASTM	Value	Units	Value	Units	Value	Units
RHEOLOGICAL								
Melt Flow Index (200 °C - 5 kg)	1133	D-1238	0.012	kg/ 10 min	12.00	g/ 10 min	2.65E-02	lb/ 10 min
Spiral Flow (220 °C)	-	D-3123	0.57	m	57	cm	22.44	in
THERMAL								
Vicat Softening Point 10N (T increase = 50 °C/h)	306	D-1525	364	K	91	°C	196	°F
Heat Distortion Temperature	75	D-648	348	K	75	°C	167	°F
Coefficient of Linear Thermal Expansion (10 ⁻⁵)	-	D-696	7.10E-03	m/K	7.10	mm/°C	1.55E-01	in/°F
MECHANICAL								
Unnotched Izod Impact Strength	180	D-256	7.50	kJ/m ²	6.90	kg-cm/cm	1.27	ft-lb/in
Tensile Strength at Yield	527	D-638	45	MPa	450.0	kg/cm ²	6528	psi
Elongation at Break	527	D-638	2	%	2	%	2	%
Flexural Modulus	178	D-790	3300	MPa	33000	kg/cm ²	478756	psi
Rockwell Hardness	2039	D-785	L-70	-	L-70	-	L-70	-
ELECTRICAL								
Dielectric Strength	-	D-149	135000	kV/m	135	kV/mm	3429	kV/in
Surface resistivity	IEC 93	-	>10e+13	Ohms ⁻¹	>10e+13	Ohms ⁻¹	>10e+13	Ohms ⁻¹
MISCELLANEOUS								
Density	-	D-792	1040	kg/m ³	1.04	g/cm ³	64.91	lb/ft ³
Mold Shrinkage	-	D-955	0.4 - 0.7	%	0.4 - 0.7	%	0.4 - 0.7	%
Water absorption	62	D-570	<0.1	%	<0.1	%	<0.1	%



RECOMMENDED INJECTION MOLDING PARAMETERS

Barrel Temperature	Value	Units
Zone 1	170 - 180	°C
Zone 2	180 - 220	°C
Zone 3	210 - 240	°C
Zone 4	210 - 240	°C
Nozzle	210 - 240	°C

General Information :

Standard Properties: All tests are carried out at 23 °C unless otherwise stated. Mechanical properties are measured on injection moulded test specimens.

Bulk Density: Bulk Density of all Natural grades is approximately 0.6 g/cm³.

TPSC Asia Polystyrene 1540 should be kept in a cool and dry place. Avoid direct exposure to sunlight.

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Information contained in this publication is true and accurate at the time of publication and to the best of our knowledge. The nominal values stated herein are obtained using laboratory test specimens. Before using one of the products mentioned herein, customers and other users should take all care in determining the suitability of such product for the intended use. Unless specifically indicated, the products mentioned herein are not suitable for applications in the pharmaceutical or medical sector. TPSC Asia Pte Ltd and its affiliates do not accept any liability whatsoever arising from the use of this information or the use, application or processing of any product described herein. No information contained in this publication can be considered as a suggestion to infringe patents. The company and its affiliates disclaim any liability that may be claimed for infringement or alleged infringement of patents.



Safety and Material Handling

TPSC ASIA PTE LTD offers a comprehensive range of TPSC POLYSTYRENE (PS) specially formulated to suit different needs. This extensive line includes crystal and impact polymers with wide-ranging properties to fulfill all customer expectations in terms of property, appearance, cost and processing. Its tremendous ease of processing and its low cost make it one of the most commonly used polymers in the food packaging, audio/video, household appliances and construction industries.

TPSC ASIA PTE LTD is committed to providing information to assist our customers in reducing the risks of handling and using our products. This bulletin sheet is intended to be a quick reference guide for TPSC ASIA PTE LTD customers to store, handle and use our products safely and in an environmentally sound manner. We aim to minimize the impact on mankind and the environment during production, storage, transportation, sale, use and disposal of our products.

Safety Data Sheets (SDS) are updated regularly, to reflect changes and updates on information in an SDS. Before handling or using any product, please request and assess the most current SDS. The information provided below is appropriate only to TPSC ASIA PTE LTD 's products as delivered. In the course of fabrication, many additives and ingredients may be added before the finished product. These must be explored *thoroughly for their* respectively health and safety considerations.

Product Stewardship Program

The aim of the product stewardship code of the responsible care initiative, which makes health, safety and environmental protection an integral part of designing, manufacturing, marketing, distributing, using, recycling and disposing our products. Successful implementation of these initiatives is a shared responsibility that includes all who come into contact with a product. TPSC ASIA PTE LTD will work with customers to help ensure that all who use and handle our products follow safe and environmentally sound practices.

General Safe Handling Information

TPSC ASIA PS is relatively inert and has a very low degree of toxicity under normal conditions of use. TPSC ASIA PS should be kept in cool and dry place. Avoid direct exposure to sunlight. Keep at room temperature. Nevertheless, safety and health

precautions should be observed in the handling and fabrication of plastic materials.

Noise is a common problem in the molding and compounding process. If possible, no worker should be exposed to excessive noise (Leq8hours 85dBA). Proper hearing protectors should be provided for workers, coupled with regular audiometric examinations.

Air borne dusts often result from sawing, filing, and sanding of plastic parts in post-moulding operations. These may cause irritation to eyes and the upper respiratory tract. Processing may also release fumes, which may contain irritating decomposition products. Adequate exhaust ventilation is recommended. Good housekeeping and controlling of dusts are necessary for safe handling of product. Workers should use approved respirators. If vapours cause irritation to eyes, a full-face respirator is recommended. Avoid accumulation of static charges during transfers in metallic systems.

Workers should be protected from the possibility of contact with *molten PS* during fabrication. Molten material may causes burns. Wash affected areas abundantly and thoroughly with water. In case of adhesion, do not try to remove product. Treat the affected areas as burns.

Proper manual handling practices should be observed in the lifting and transportation of PS packages. Occurrences in back and arm injuries are common in erroneous lifting techniques.

Flammability and Combustibility

Thermal decomposition at 200 °C gives off flammable and harmful products such as styrene, ketones, toluenes and alcohol. There would be formation of toxic products, such as carbon oxides through combustion.

In fighting fire, wear a self-contained breathing apparatus and protective suit. Water or water fog are the preferred extinguishing media. Foam, alcohol resistant foam, carbon dioxide, or dry chemicals may also be used.

Safe Disposal

Disposal methods must be in compliance with international, national and local laws and regulations. Destroy the product by incineration at an approved waste disposal site.

However, PS offers many possibilities for post consumer recycling such as: (1) Energy recycling using heat recovery systems for urban and industrial heating systems, (2) Material recycling. PS should be recycled whenever possible. Because of their high energy content, plastics can help the entire waste mix burn hotter and more completely in a waste-to-energy incinerator.

Care for the Environment

PS must not be discarded indiscriminately into the waterways nor land.

Heavy metals are not used in the manufacture of TPSC ASIA PS. As such, disposal of PS via convention methods would be safe for the environment. Incineration of PS would not emit heavy metals or deleterious dioxins into the environment. There would be no leaching of heavy metals into the earth when the incineration ash is land filled.

Customer Notice

TPSC ASIA PTE LTD stresses the importance of health and environmental protection during the entire lifetime of all TPSC ASIA PTE LTD 's products, and calls for TPSC ASIA PTE LTD to cooperate closely with its customers and partners. To help ensure that TPSC ASIA PTE LTD 's products are not used improperly, TPSC ASIA PTE LTD 's personnel will assist customers in dealing with product safety, health and environmental considerations.

This information is provided for GENERAL INFORMATION ONLY. TPSC ASIA PTE LTD and its affiliates provide a Safety Data Sheet (SDS) for this product, in the appropriate language, according to applicable laws and regulations.

Anyone using this product should carefully review the SDS, as well as any other applicable precautions and instructions for use. No liability whatsoever can be accepted by TPSC ASIA PTE LTD and its affiliates with regard to the handling, processing or use of the product or products concerned which must in all cases be used in accordance with all applicable laws and regulations.

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