

Injection Molding of STYRON 6500 Ignition Resistant Polystyrene Resin

Drying Recommendations

Moisture Content: It is recommended to dry this resin to less than 0.02% moisture.

Dryer: A desiccant-type dryer is recommended for this material. Hopper dryer may also be needed.

Dew Point: -20°F (-30°C) or lower is desired.

Drying Time: A minimum of 2 hours at 180-185°F (82-85°C) is recommended.

Equipment Specifications

Shot Size: As required to fill part.

Clamp Tonnage: 2.0-3.0 tons/in² (0.28-0.42 tonnes/cm²) of projected surface area.

Barrel Capacity: Minimum of three times shot size, but no greater than six times shot size (i.e.: if shot is 10 oz., barrel capacity should be 30-40 oz., but no greater than 60 oz.). For short barrel machines, if shot size exceeds 50% of barrel capacity, increase “feed” and “transition” barrel temperatures by 15°F (8°C).

Process Conditions

Melt Temperature: Can be varied as required to fill part. See Table 1.

Mold Temperature: Can be changed to affect gloss or demolding characteristics. See Table 1.

Manifold/Drop Temperature: The manifold/drop temperature is typically set the same as the melt temperature. Depending on the tooling design, the manifold/drop temperature may be reduced up to 30° F (17°C) below the melt temperature to improve aesthetics and/or minimize material degradation.

Purging/Shutdown: For short interruptions in production, empty the barrel and reduce barrel temperatures. For extended shutdowns, purge the machine with a purging compound or general purpose polystyrene before shutting down machine.

Table 1: Machine Temperature Recommendations

Temperatures	Range, °F (°C)	Aim, °F (°C)
Melt Temperature	450-480 (232-249)	465 (241)
Mold Temperature	100-150 (40-65)	120 (49)
Barrel – Feed	360-390 (182-199)	375 (191)
Barrel – Transition	410-440 (210-227)	425 (218)
Barrel – Metering	435-475 (224-246)	450 (232)
Nozzle	445-475 (229-246)	465 (241)

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.



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North America

U.S. +1-855-TRINSEO (+1-855-874-6736)
U.S. & Canada +1-989-633-1718

Latin America

Brazil +55-11-5184-8722
Argentina, Chile, South Region of LAA +54-11-4319-0100
Mexico, Colombia, North Region of LAA +52-55-5201-4700

Europe/Middle East/Africa +800-444-11-444
+31-11567-2601

Asia Pacific +603-7965-53-19

China +86-21-3851-1017

Email CI@trinseo.com

www.trinseo.com

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