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DOKI® POLISTIREN 680 L

General Purpose Polystyrene

Material Description

DOKI® POLISTIREN 680 L is transparent general purpose polystyrene exhibiting good melt flow properties.

DOKI® POLISTIREN 680 L is basically intended for extrusion, foam extrusion, and injection moulding of thick-walled moulded products.

DOKI® POLISTIREN 680 L is characterized by good thermal and dimensional stability of moulded products.

DOKI® POLISTIREN 680 L is processed in melt temperature range of 180 °C to 230 °C.

Mould shrinkage: 0.4 – 0.6 %

Mould temperature: 20 – 60 °C

Application

- Production of foamed extruded polystyrene panels (XPS)
- Packaging in cosmetics and medicine
- Mixing with other DOKI® POLISTIREN grades

Property ^{1,2}	ISO Standard	Value	Unit
Density	1183	1.05	g/cm ³
Bulk Density	60	0.60	g/cm ³
VICAT softening temperature	306 B/50	98	°C
Tensile strength at yield	527/2	40	MPa
Tensile strength at break	527/2	40	MPa
Elongation at break	527/2	1	%
Tensile modulus	527/2	3200	MPa
Izod impact resistance, notched	180/4A	≤ 1	kJ/m ²
Rockwell hardness	2039	105	Scale R
Melt Flow Rate (condition H)	1133	4.0	g/10 min

¹ Typical values that do not represent specification limit values

² Injection moulded test samples

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Storage and Handling

DOKI® POLISTIREN 680 L is packed in polyethylene bags of 25 kg stacked up on wooden pallets having total dimensions of 1700 x 1300 x 1050 mm and total mass of 1290 kg (1250 kg net). The pallets are covered and secured with stretch film. The product is also transported by road tankers.

DOKI® POLISTIREN 680 L should not be exposed to direct sunlight, which can affect its properties. If stored in unfavourable climatic conditions (great temperature variations and high moisture content) moisture can condense in bags.

Physiological Properties

DOKI® POLISTIREN 680 L complies with the requirements of the European Directive 2004/19/ EC (an amended edition 2002/72/EC), relating to plastic materials and articles intended to come into contact with foodstuffs. **DOKI® POLISTIREN 680 L** meets the requirements of the European Directive 94/62/EC of the European law on packaging material.

Material Safety Data Sheet is available on www.dioki.hr

Technical Service

Further information is available to **DOKI® POLISTIREN 680 L** end users at: Tel: ++ 385 1 2483 670; Fax: ++385 1 2404 383; E-mail: dioki@dioki.hr

Sale

All information on the sale of DIOKI's products can be obtained from DIOKI's Commercial Department, Tel: ++385 1 2483 000; Fax: ++385 1 2407 362 or ++385 1 2404 975; E-mail: dioki@dioki.hr, DIOKI d.d., 10 000 Zagreb, Žitnjak bb, CROATIA