

TABLE 2: TECHNICAL PRODUCTS SPECIFICATIONS

Product	Pentane, %	Resid. Monomer ppm	Bead size, mm	
Styropek® P-240H	5.2 - 5.8%	< 1000	0.85 - 1.70	97% min
Styropek® P-240AH	5.2 - 5.8%	< 1000	0.85 - 1.70	97% min
Styropek® P-340H	5.2 - 5.8%	< 1000	0.6 – 1.18	97% min
Styropek® P-440H	5.2 - 5.8%	< 1000	0.355 - 0.85 < 0.355	97% min 2% max
Styropek® P-440MH	5.2 - 5.8%	< 1000	0.355 - 0.85 < 0.355	97% min 2% max
Styropek® P-540H	5.2 - 5.8%	< 1000	0.30 - 0.50 < 0.30	96% min 3% max



PROCESSING

Polystyrene foams made from Styropek® P-40 products are produced in three stages: pre-expansion, intermediate aging and molding. Full details please contact Styropek Technical / Sales Service.

PRE-EXPANSION

The minimum density achievable depends on the pre-expansion equipment and technique used. Styropek® P-40 products should be processed in batch pre-expander and can reach bulk densities shown in Table 3. In continuous pre-expander the densities can be lower than 28 kg/m³ (1.75 pcf).

The pressure in pre-expansion should be 0.25 to 0.50 bar. Care should be taken during expansion, as prolonged steam times will result in excessive loss of pentane and difficulty in achieving acceptable fusion during molding.

TABLE 3

Product	Typical expanded density range
Styropek® P-240H	16 – 40 kg/m ³ - (01.00 – 2.50 pcf)
Styropek® P-240AH	18 – 40 kg/m ³ - (1.13 – 2.50 pcf)
Styropek® P-340H	16 – 32 kg/m ³ - (1.00 – 2.00 pcf)
Styropek® P-440H	20 – 40 kg/m ³ - (1.25 – 2.50 pcf)
Styropek® P-440MH	20 – 48 kg/m ³ - (1.25 – 3.00 pcf)
Styropek® P-540H	30 – 80 kg/m ³ - (1.87 – 5.00 pcf)

pcf = pound per cubic foot = lb/ft³

INTERMEDIATE AGING

The minimum recommended pre-puff intermediate aging period by products is 2 hr. depending of density and ambient temperature. Care should be taken when aging products in excess of 24 hr. because conditions of molding may increase times and steam pressures in order to obtain acceptable fusions.

MOLDING

These products are intended for molding on automatic molding machines. Molding can be accomplished under a wide range of conditions and densities.

SAFETY

Styropek® P-40 products and the finished foam products could form flammable/explosives mixtures with

the air and the blowing agent (pentane) that migrates from the material. Therefore, all possible ignition sources must be eliminated (flames, sparks and electrostatic charges).

Adequate ventilation in all processing areas must be provided to prevent hazardous accumulations of pentane vapors.

For more information regarding safety, please refer to the Safety Data Sheets (SDS) and contact Styropek Technical / Sales Representative.

BIOLOGICAL EFFECTS

None of its compounds are water soluble and do not emit hydro soluble substances that pollute underground water. In the dumping ground they do not decompose nor form any polluting substances.

Observed the local regulations, expanded Styropek® P-40 material can be disposed as domestic garbage. Styropek® P-40 products have been produced and transformed for over 50 years, and during this period no harmful health effects have been observed.

Styropek® P-40 products are 100% recyclable.

CHEMICAL EFFECTS

For more Information about chemical resistance of Styropek® P-40 products please contact Styropek Technical / Sales representative. Extended exposure to ultraviolet light may cause the EPS foam to turn yellowish and the surface to become brittle.

OBSERVATIONS

IMPORTANT: The information provided in this publication is based on STYROPEK, S.A. DE C.V. best knowledge and experience. In view of the many factors that may affect the processing and application of the products, this data does not relieve molders from the responsibility of carrying out their own tests and experiments; neither does it imply any legally binding assurance of certain properties or of suitability for a specific purpose. It is the responsibility of those to whom we supply our products to comply with any existing laws and legislation as well as proprietary rights, which STYROPEK S.A DE C.V. is holder.

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