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**A SERIES –
STANDARD GRADE**

Sunchem A series EPS belongs to the raw material in standard expansion ratio to realize relatively light gram weight by one-time expansion and the lighter density after several expansions. It can be widely used in machinery and electronic products packaging, agriculture and fishery packaging vessel, thermal insulation and heat preservation material in building, fishery flotation buoy, crafts, food and drinking container, decorative material, lost foam casting and light apparatus with resistance to attack.

The expansion ratio of A series can be a little higher to obtain good preservation and rigid molding. The product has the properties of good fusion, smooth surface, wide option for operation, good applicability and difficult shrinkage and distortion.

Series	Grade	Bead Size (mm)	Foam density(g/l)	Principal Applications
A-STANDARD GRADE	A-103	1.00-1.60	11-14	Use for block and low density product
	A-104	0.85-1.25	12-15	Use for product more than 12mm thick
	A-105	0.70-1.00	13-17	Use for middle density packing product
	A-106	0.50-0.80	14-18	Use for product more than 8mm thick
	A-107	0.40-0.60	15-18	Use for product more than 6mm thick
	A-108	0.30-0.50	20-28	Use for molding and headpiece etc.

Technical Specification:

Specifications	A-series
Sieving	95%
Bulk density	0.5-0.6
Blowing agent	Pentane
Blowing agent	>6.0%
Residual Monomer	≤0.3%
Moisture content	≤0.5%
CFC content	nil

Processing:

1. Pre-expansion: Batch pre-expander("FANGYUAN" PSY-90 type)

Item	A-series
Main steam pressure(kg/cm²)	3 - 4
Steam pressure for pre-expanding(kg/cm²)	0.10
Temperature in vessel(°C)	92-98
Feeding speed(kg/times)	7-10
Heating time(s)	25 - 40
Weight(g/L)	12 - 15



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2. Aging time:

Maturation after pre-expansion	A-series
Summer & Autumn	3 – 4h
Winter & Spring	3 – 4h

3. Molding: (“jin Cheng” JC-II D type)

Molding data	A-series
Main steam pressure(kg/cm ²)	5.0 – 7.0
Air pressure(kg/cm ²)	5.0 – 7.0
Cooling water pressure(kg/cm ²)	3.5 – 5.0
Penetrating pressure(kg/cm ²)	0.50-0.65
Molding pressure(kg/cm ²)	0.50-0.63
Mold fixing pressure(kg/cm ²)	0.40-0.50
Mold moving pressure(kg/cm ²)	0.35-0.45
Penetrating heating (s)	11-17
Molding heating (s)	6-10
Heat preserving time (s)	5
Water cooling time (s)	15-25
Draining (s)	2-5
Sealed time (s)	10-15
Cycle time (s)	130-150

Notice:

The above tables show the types and grades of SUNCHEM EPS that are currently available.

IMPORTANT: The data descriptions, designs, and information contained herein are believed to be accurate to the best knowledge of SUNCHEM. It is intended for your guidance only.

Considering different equipments etc., the processing data above is only for reference.