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**B SERIES –
HIGH EXPANSION
GRADE**

Sunchem B series EPS is the raw material of high expansion ratio to realize light beads in gram weight by one-time expansion and even suitable to make lighter plastic foam by several expansions. Therefore, it should be better to meet with the product of less than 18g/l by one-time expansion and 10g/l by several expansions to be widely used in machinery and electronic product packaging, fishery flotation buoy, crafts, decorative material, lost foam casting and light apparatus with resistance to attack as well as light board.

B series obtains the properties of high expansion ratio, rapid expansion, low energy consumption, short aging time and molding cycle. Its product also realizes the characteristics of good fusion, smooth surface, stable material, wide option as well as difficult shrinkage and distortion.

Series	Grade	Bead Size(mm)	Foam density(g/l)	Principal Applications
B-HIGH EXPANSION GRADE	B-103	1.00-1.60	10-12.5	Use for electric packing, block, craftwork, box etc., especially use for low density block
	B-104	0.85-1.25	11-14	
	B-105	0.70-1.00	12.5-13	
	B-106	0.50-0.80	13-18	
	B-107	0.40-0.60	25-33	
	B-108	0.30-0.50	18-50	

Technical Specification:

Specifications	B-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" PSJ-110 type)

Item	B-series
Main steam pressure(kg/cm ²)	4.5 - 6
Steam pressure for pre-expanding(kg/cm ²)	1.0
Temperature in vessel(°C)	105-110
Feeding speed(kg/times)	4-5
Heating time(s)	23 - 30
Weight(g/L)	9.5 - 11.5

2. Aging time:

Maturation after pre-expansion	B-series
Summer & Autumn	3 – 4h
Winter & Spring	4 – 5h

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

Molding data	B-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)	8-12
Molding heating (s)	4-6
Heat preserving time (s)	5
Water cooling time (s)	15-30
Draining (s)	2-5
Sealed time (s)	15-20
Cycle time (s)	130-140

4. Big size Molding of construction material:

Big Size Molding of construction material	B-104	B-105
	PSB-600C(size:6.06m*1.28m*1.005m)	
Aging time(g/l)	6.2 – 7.0	6.8-7.4
Air pressure(Mpa)	0.08	0.08
Preheating time(s)	8	8
Penetrating pressure 1(Mpa)	0.061	0.05
Penetrating pressure 2(Mpa)	0.08	0.08
Penetrating time 1(s)	11	10.5
Penetrating time 2(s)	1.3	1.3
Heat preserving time (s)	12	12
Blow down time(s)	12	12
Cooling time(s)	250	250
Unlock time (s)	5.4	5.4
Molding unload (s)	13.2	13.2
Demoulding (s)	1	1

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.