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**D SERIES –
FAST CYCLING
GRADE**

Sunchem D series EPS's molecular weight and blowing agent is less than A series, so its heating time and aging time is less than A series. Therefore, it can reduce energy use and improve efficiency. D series obtains high expansion ratio, short aging time, close cell size and flat appearance. It is suitable for rapid cooling in automatic molding machine.

D series EPS is widely used in packing materials of protecting articles from breakage & Thermal insulations.

Series	Grade	Bead Size(mm)	Foam density(g/l)	Principal Applications
D-FAST CYCLING GRADE	D-103	1.00-1.60	14-17	Use for electric packing, block, china packing and high density product
	D-104	0.85-1.25	15-20	
	D-105	0.70-1.00	17-25	
	D-106	0.50-0.80	18-29	

Technical Specification:

Specifications	D-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	D-series
Main steam pressure(kg/cm ²)	5 - 6
Steam pressure for pre-expanding(kg/cm ²)	1.10
Temperature in vessel(°C)	108-110
Feeding speed(kg/times)	4.8-5.6
Heating time(s)	20 - 35
Weight(g/L)	10.5 - 13.5

2. Aging time:

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

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

Molding data	D-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)	10-15
Molding heating (s)	6-8
Heat preserving time (s)	5
Water cooling time (s)	5-15
Draining (s)	2-5
Sealed time (s)	5-12
Cycle time (s)	100-120

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.