

**FEATURES:**

Resirene 6420 is a HIPS grade suitable for extrusion processes

- High Impact
- High Productivity
- Low Flow
- Easy processing
- FDA: 21 CFR 177.1640

**APPLICATIONS:**

Extrusion processes, sheets for POP (Point Of Purchase) displays, deep draw thermoforming, blends with GPPS for disposable packaging, cups and plates

**PROPERTIES**

PHYSICAL

|                                      | English                  | Value       | Metric                  | Value       | METHOD     |
|--------------------------------------|--------------------------|-------------|-------------------------|-------------|------------|
| <b>Melt Flow Rate (200 °C/5.0Kg)</b> | <b>g/10 min</b>          | <b>2.80</b> | <b>g/10 min</b>         | <b>2.80</b> | ASTM D1238 |
| <b>Specific Gravity</b>              | <b>lb/in<sup>3</sup></b> | <b>0.04</b> | <b>g/cm<sup>3</sup></b> | <b>1.05</b> | ISO 1183   |

MECHANICAL

|                         |            |                |            |                |           |
|-------------------------|------------|----------------|------------|----------------|-----------|
| <b>Break Elongation</b> | <b>%</b>   | <b>76</b>      | <b>%</b>   | <b>75.5</b>    | ASTM D638 |
| <b>Tensile Modulus</b>  | <b>psi</b> | <b>295,470</b> | <b>MPa</b> | <b>2,037.2</b> | ASTM D638 |

IMPACT

|                                      |                  |             |            |            |           |
|--------------------------------------|------------------|-------------|------------|------------|-----------|
| <b>Notched Izod Impact (0.50 in)</b> | <b>ft-lbf/in</b> | <b>1.94</b> | <b>J/m</b> | <b>104</b> | ASTM D256 |
|--------------------------------------|------------------|-------------|------------|------------|-----------|

THERMAL

|                                   |           |            |           |           |            |
|-----------------------------------|-----------|------------|-----------|-----------|------------|
| <b>Vicat Temperature</b>          | <b>°F</b> | <b>180</b> | <b>°C</b> | <b>82</b> | ASTM D1525 |
| <b>HDT @ 264 psi (unannealed)</b> | <b>°F</b> | <b>162</b> | <b>°C</b> | <b>72</b> | ASTM D648  |

Typical values represent average laboratory values and are intended as guides only, not as specific specification limits. Properties designated in this standar have been determined in accordance with the current issue of the specified testing methods.

**INJECTION MOLDING CONDITIONS**

|                     | <b>°C</b> | <b>°F</b> |
|---------------------|-----------|-----------|
| Profile             | 200-230   | 392-446   |
| Maximum Recommended | 240       | 464       |

**EXTRUSION CONDITIONS**

|                  | <b>°C</b> | <b>°F</b> |
|------------------|-----------|-----------|
| Feeding Zone     | 80        | 176       |
| Initial Zone     | 180       | 356       |
| Compression Zone | 190       | 374       |
| Transport Zone   | 200       | 392       |
| Pumping Zone     | 210       | 410       |

**ADDITIONAL INFORMATION**

**WARNING:**

Combustion of this material may cause hazardous fumes and gases that may be dangerous to one's health, especially in enclosed places. It should be noted that excessive heating or long residence times may cause degradation or yellowing.

**NOTE:**

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