



6470

HIGH IMPACT POLYSTYRENE
HIPS

FEATURES:

Resirene 6470 is a HIPS grade suitable for extrusion processes

- High Impact
- High Productivity
- Low Flow
- High Gloss
- 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, garment hangers

PROPERTIES

PHYSICAL	English	Value	Metric	Value	METHOD
Melt Flow Rate (200 °C/5.0Kg)	g/10 min	3.20	g/10 min	3.20	ASTM D1238
Specific Gravity	lb/in³	0.04	g/cm³	1.05	ISO 1183
MECHANICAL					
Break Elongation	%	68	%	68.0	ASTM D638
Tensile Modulus	psi	257,791	MPa	1,777.4	ASTM D638
IMPACT					
Notched Izod Impact (0.50 in)	ft-lbf/in	2.10	J/m	112	ASTM D256
THERMAL					
Vicat Temperature	°F	180	°C	82	ASTM D1525
HDT @ 264 psi (unannealed)	°F	162	°C	72	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

EXTRUSION CONDITIONS

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

	<u>°C</u>	<u>°F</u>
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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