

General Purpose Polystyrene

FEATURES

- High Flow
- Easy Processing
- High Productivity
- FDA: 21 CFR 177.1640

APPLICATIONS Injection molding, Thin wall devices, Intricate molds, Disposables, Cosmetics cases

PROPERTIES

	ENGLISH UNIT	TYPICAL VALUES	S.I. UNITS	TYPICAL VALUES	ASTM
PHYSICAL					
Specific Gravity	-	1.05	-	1.05	D792
Melt Flow Rate (G-200°C/5kg)	g/10 min	16	g/10 min	16	D1238
Mold Shrinkage	in/in	4E-03	mm/mm	4E-03	D955
MECHANICAL					
Tensile Strength, Break	psi	5,200	MPa	36	D638
Break Elongation	%	2.4	%	2.4	D638
Tensile Modulus	psi	350,000	MPa	2,413	D638
IMPACT RESISTANCE					
Notched Izod Impact (0.500 in)	ft-lb/in	0.3	J/m	16	D256
THERMAL					
HDT @ 264 psi (unannealed)	°F	162	°C	72	D648
Vicat Softening Temperature	°F	176	°C	80	D1525
IGNITION CHARACTERISTICS					
Flammability 0.060 in	-	HB	-	HB	UL 94
OPTICAL					
Transmittance	%	90	%	90	D 1003

.Typical Values represent average laboratory values and are intended as guides only, not as specific specification limits.

.Properties designated in this standard have been determined in accordance with the current issues of the specified testing methods.

.All molded samples were an 1/8 inch (3.2 mm) thick unless noted

AVAILABILITY

Resirene's styrenic resins are available in bulk, 25 kg bags (55 lbs), and 500 - 750 kg boxes (1,100 - 1,652 lbs).

FDA

HF-555 complies with the specifications contained in U.S.A. Food and Drug Administration (FDA) regulation 21 CFR 177.1640 for polystyrene and rubber-modified polystyrene, and thus may be used in the United States as an article or a component of an article intended for use in contact with food, subject to any limitations described in the regulations.

ENVIRONMENTAL

Resirene's materials are biological and chemically inert. It is recommended to recycle HF-555. If you require dispose it follow indications established by government laws, related norms and the material safety data sheet.

MOLDING CONDITIONS

In order to obtain the best appearance in molded parts, it is recommended a highly polished mold, with such polished it can be obtained high gloss parts. In general, mold control temperature has no effect upon material and finished product clear.

These conditions may vary from a molding machine to another, but following conditions are suggested for a start-up approach.

	START POINT	RANGE
Melt Temperature	410 °F (210 °C)	392 - 446 °F - (200 - 230 °C)
Mold Temperature	120 °F (49 °C)	100 - 180 °F - (38 - 82 °C)
Maximum Recommended Temperature	464 °F (240 °C)	

WARNING: As most of plastics materials, combustion of this material may cause hazardous fumes and gases, as well as situations that could be dangerous for health, specially in closed places. It should be noted that excessive heating or too long residence times may cause discoloration, degradation or yellowing.

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