**HIPS8020**

Molding Grade HIPS

**Typical Material Properties**

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| --- | --- | --- |
| Physical Properties | Nominal Values | ASTM Test |
| Specific Gravity | 1.04 | D792 |
| Melt Flow (200 °C/5.0 kg) | 8.0 g/10 min | D1238 |

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| Mechanical Properties |  |  |
| Tensile Strength at Yield | 3,500 psi | D638 |
| Flexural Modulus | 260,000 psi | D790 |
| Flexural Strength at Yield | 5,000 psi | D790 |

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| Impact |  |  |
| Notched Izod Impact (73 °F, 0.125 in) | 1.5 ft-lb/in | D256 |

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| Thermal |  |  |
| DTUL @ 264 psi-unannealed (0.125 in) | 175 °F | D648 |

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| Mold Shrinkage |  |  |
| Linear Flow | .004 - .008 in/in | D955 |

**Recommended Processing Guidelines**

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| --- | --- |
|  | Nominal Values |
| Drying Time and Temperature | 0 – 1.0 hr at 160 - 180 °F |
| Suggested Max Moisture | N/A |
| Rear Temperature | 350 - 400 °F |
| Middle Temperature | 370– 450 °F |
| Front Temperature | 370 - 450 °F |
| Nozzle Temperature | 370 - 450 °F |
| Processing (melt) Temperature | 370 - 450 °F |
| Mold Temperature | 100 - 170 °F |
| Back Pressure | 25 - 100 psi |
| Screw Speed | 25 – 75 rpm |

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.