

TECHNICAL DATA SHEET

RESIRENE® HH 104

GENERAL PURPOSE POLYSTYRENE (GPPS)

FEATURES

- Medium Flow
- Heat Resistance
- Good Mold Release
- FDA Rating: 21 CFR 177.1640

APPLICATIONS

- Injection Molding
- Pen Barrels
- Disposable Items
- Scholar and Office Supplies

PROPERTIES

Physical	English	Value	Metric	Value	Test Method
Melt Flow Rate (200°C/5.0 Kg)	g/10 min	4	g/10 min	4	ASTM D1238
Density	lb/ft ³	65	g/cm ³	1.04	ASTM D792
Mechanical					
Break Elongation	%	5	%	5	ASTM D638
Tensile Strength, Break	Psi	6,630	MPa	46	ASTM D638
Tensile Modulus	Kpsi	500	MPa	3,450	ASTM D638
Thermal					
Vicat Temperature	°F	225	°C	107	ASTM D1525
HDT @ 264 psi (unannealed)	°F	185	°C	85	ASTM D648
Ignition Characteristics					
Flammability	-	HB	-	HB	UL 94
Optical					
Light Transmittance	%	90	%	90	ASTM D1003

Properties reported in this data sheet are determined according to referred standard methods. Values shown represent averages from typical results measured in the laboratory and are provided only as a guide, not as specification limits.

INJECTION MOLDING CONDITIONS

	°C	°F
Rear	200-210	390-410
Center	210-220	410-430
Front	220-230	430-445
Nozzle	230-240	445-465

ADDITIONAL INFORMATION

Warning:

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

Note:

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