Resirene

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

TYPICAL PROPERTY VALUES

Physical	English	Value	SI	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
Mold Shrinkage	%	0.3 – 0.7	mm/mm	$3 – 7 \times 10^{-3}$	ASTM D 955
Mechanical					
Break Elongation	%	2.2	%	2.2	ASTM D638
Tensile Strength, Break	psi	6,700	MPa	46	ASTM D638
Tensile Modulus	kpsi	430	MPa	2,960	ASTM D638
Thermal					
VICAT Softening Temperature (120°C/, 10 N)	°F	228	°C	109	ASTM D1525
Heat Deflection Temperature (264 psi unannealed)	°F	176	°C	80	ASTM D648
Ignition Characteristics					
Flammability	-	HB	-	HB	UL 94
Optical					
Light Transmission	%	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 CONDITIONS

	°C	°F
Initial Zone	40	104
Feeding zone	180-190	356-374
Transport zone	190-200	374-392
Compression zone	200-210	392-410
Pumping zone	210-220	410-428
Melt	230	446

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.

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Carretera Fed. Puebla-Tlaxcala
Km. 15.5 - CP 90780
Xicohtzinco, Tlaxcala, México

MEX 1 800 RESINAS
USA 1 866 372 3470
www.resirene.com.mx