



Technical Data Sheet

Grade

MWR HIPS13100

Product Description:

High Impact Polystyrene

Physical Properties	Method	English	SI
Specific Gravity	D 792	-	1.040
Melt Flow Rate (200/5.0)	D 1238	-	10 g/10 minutes
Linear Mold Shrinkage (Typical)	D 955	0.006 in/in	0.006 mm/mm
Mechanical Properties	Method	English	SI
Tensile Strength at Yield	D 638	3900 psi	26.9 Mpa
Tensile Elongation at Break	D 638	45.0 %	45.0 %
Flexural Modulus (Tangent)	D 790	280000 psi	1930 Mpa
Izod Impact (notched)	D 256	2.0 ft-lb/in	110 J/m
Hardness (Rockwell)	D 785	55 R	55 R
Thermal Properties	Method	English	SI
Heat Deflection Temperature at 66 psi	D 648	188 F	87 C
Heat Deflection Temperature at 264 psi	D 648	178 F	81 C
Processing (Injection Molding)		English	SI
Drying Temperature		170 F	77 C
Drying Time		3 hrs	3 hrs
Max Moisture Content		0.20 %	0.20 %
Rear Barrel Temperature		410 F	210 C
Middle Barrel Temperature		420 F	216 C
Front Barrel Temperature		430 F	221 C
Nozzle Temperature		430 F	221 C
Stock Temperature		440 F	227 C
Mold Temperature		120 F	49 C

Comments:

Drying is usually not necessary

Values shown are averages and not to be construed as specifications.

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