

HIPS 406AF

Injection Molding

Description

Flame Retardant

Application

Office Appliances (Parts of Printer or Copier)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.1
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.8
Melt Flow Rate	200 °C/5kg	ASTM D1238	g/10min	11
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	330
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	>5
@ Break	50mm/min		%	50
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	530
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	25,000
Tear Strength @ Break	50mm/min	ASTM D624	kg/cm	
IZOD Impact Strength, 6.4mm (Notched)		ASTM D256		
	23 °C		kg·cm/cm	5
	-30 °C		kg·cm/cm	4
IZOD Impact Strength, 3.2mm (Notched)		ASTM D256		
	23 °C		kg·cm/cm	8
	-30 °C		kg·cm/cm	4
Rockwell Hardness	R-Scale	ASTM D785	-	103
Heat Deflection Temperature, 6.4mm (Unannealed)		ASTM D648		
	18.6kg		°C	79
	4.6kg		°C	85
Vicat Softening Temperature		ASTM D1525		
	5kg, 50 °C/h		°C	85
Flammability		UL94		
1.5mm			class	V-2
2.5mm			class	V-2
3.0mm			class	V-2
Relative Temperature Index		UL 746B		
Electrical			°C	50
Mechanical with Impact			°C	50
Mechanical without Impact			°C	50

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	60 ~ 70	
Drying Time	hrs	3 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	°C	200 ~ 230	
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	190 ~ 200
	Front	°C	200 ~ 210
Nozzle Temperature	°C	200 ~ 230	
Mold Temperature	°C	40 ~ 60	
Back Pressure	kg/cm ²	300 ~ 600	
Screw Speed	rpm	30 ~ 60	

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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