




## Material Datasheet 5

<b>Trade Name : HIPS White</b>	
<b>Material : High Impact Polystyrene (HIPS)</b>	
<b>Grade : HIPS WH 1206</b>	

Properties	Test Method	Test Condition	Unit	Typical Value
<b>Physical</b>				
Specific Gravity	ASTM D792		g/cm <sup>3</sup>	1.04 - 1.08
Water Absorption	ASTM D570	23°C	%	0.10 - 0.13
<b>Rheological</b>				
Melt Flow Index	ASTM D1238	200°C - 5kg	g/10min	9 - 12
<b>Mechanical</b>				
Tensile Strength	ASTM D638		kg/cm <sup>2</sup>	160 - 240
Tensile Modulus	ASTM D638		kg/cm <sup>2</sup>	26 - 40
Flexural Strength	ASTM D790		kg/cm <sup>2</sup>	320 - 400
Flexural Modulus	ASTM D790		kg/cm <sup>2</sup>	16000 - 24000
Izod Impact	ASTM D256	V-notched, 1/8"	kg.cm/cm	5 - 9
<b>Thermal</b>				
Heat Distortion Temp.	ASTM D648	Unannealed	°C	76 - 84
<b>Flammability</b>				
Flammability	UL 94	All Colours		HB

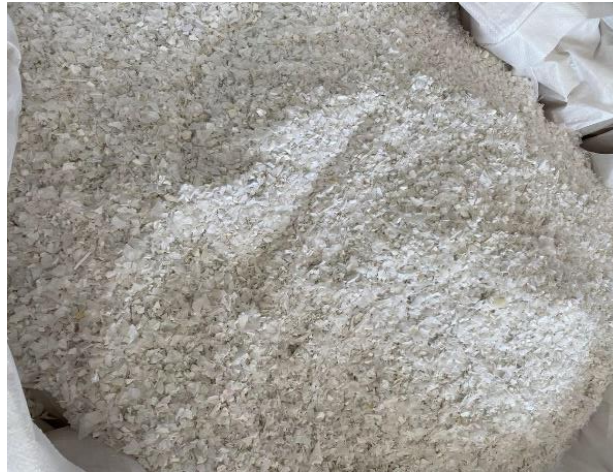
### Recommended Injection Molding Parameters

Barrel Temperature	Value	Mold Temperature	Value
Zone 1	150 - 180°C	Fixed Half	30 - 50°C
Zone 2	170 - 210°C	Moving Half	20 - 40°C
Zone 3	190 - 230°C	Injection Pressure	200 - 400 Bars
Zone 4	200 - 240°C	Hold on Pressure	20 - 80 Bars
Nozzle	210 - 250°C	Screw Back Pressure	10 - 50 Bars
		Screw Speed	50 - 200 RPM
		Drying Hour	2
		Drying Temperature	70°C

The data are intended as a general guide only and do not necessarily represent results that may be obtained elsewhere. For further information, please contact or fax to Zinco Colours Technical Services Department.



## Raw Materials



## Finished Products

### Electric Switch Covers

