

Technical Data Sheet

FR HIPS(Flame retardant High Impact Poly Styrene)
HFH 407

Features High impact, Non-Deca type
Applications TV housing, Electronics

Physical	Test Method	Value
Density	ASTM D792	1.18 g/cm ³
Melt Flow Index (200°C, 5kg)	ASTM D1238	10 g/10min
Mold Shrinkage	ASTM D955	0.3 ~ 0.6 %
Water absorption	ASTM D570	0.5 %
Mechanical	Test Method	Value
Tensile Strength	ASTM D638	250 kg/cm ² (3,550) (psi)
Elongation	ASTM D638	35 %
Flexural Strength	ASTM D790	320 kg/cm ² (4,550) (psi)
Flexural Modulus	ASTM D790	21,000 kg/cm ² (298,000) (psi)
Izod Impact Strength(3.2mm)	ASTM D256	8 kgcm/cm (1.4) (ft-lb/in)
Rockwell Hardness(L scale)	ASTM D785	55
Thermal	Test Method	Value
Heat Deflection Temperature(18.6kgf/cm ²)	ASTM D648	75 °C (167) (°F)
Vicat Softening Temperature(1kg, 50°C/h)	ASTM D1525	94 °C (201) (°F)
Flammability	Test Method	Value
Flame Rating - UL (1.6mm, 3.2mm)	UL 94	V-0

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Molding Condition

Injection Guide	Unit	Value
Nozzle	°C	200~220
Front	°C	200~220
Middle	°C	200~220
Rear	°C	190~210
Hopper Throat	°C	45
Mold	°C	40~60

Drying	Unit	Value
Temperature	°C	60~80
Time	hr	2~4

Notes

These are just typical properties, not specifications. Users should confirm results by their own test.

Processing

HFH 407 can be injection molded under different conditions depending on machinery available and articles molded. It is suitable for gas assisted injection molding.

Customer Notice

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