

Technical Data Sheet

**HIPS(High Impact Poly Styrene)
HI 425EH**

Features

Cold resistance extrusion

Applications

Disposable cups, Food packing sheet, Wrapping films, Trays,
Washing machines

Physical	Test Method	Value
Density	ISO 1183	1.03 g/cm ³
Melt Flow Index (200°C, 5kg)	ISO 1133	4.5 g/10min
Mold Shrinkage	ISO 294-4	0.3 ~ 0.6 %
Water absorption	ISO 62	0.03 %

Mechanical	Test Method	Value
Tensile Strength	ISO 527	25 Mpa
Elongation	ISO 527	60 %
Flexural Strength	ISO 178	29 MPa
Flexural Modulus	ISO 178	1,710 Mpa
Izod Impact Strength(3.2mm)	ISO 180/1A	9.5 KJ/m ²
Rockwell Hardness(L scale)	ISO 2039-2	60

Thermal	Test Method	Value
Heat Deflection Temperature(18.6kgf/cm ²)	ISO 75-2	74 °C
Vicat Softening Temperature(1kg, 50°C/h)	ISO 306	95 °C

Flammability	Test Method	Value
Flame Rating - UL (1.6mm)	UL 94	HB

Notes

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

Technical Data Sheet

HIPS(High Impact Poly Styrene)
HI 425EH

Processing guide

Injection Guide	Unit	Value
Nozzle	°C	190~220
Front	°C	190~210
Middle	°C	180~200
Rear	°C	170~190
Hopper Throat	°C	45
Mold	°C	40~60

Extrusion Guide	Unit	Value
Zone 1	°C	170~190
Zone 2	°C	180~200
Zone 3	°C	180~210
Zone 4	°C	190~220
Zone 5	°C	200~220
Screen Changer	°C	190~210
Adaptor	°C	200
Die	°C	190~210

Drying	Unit	Value
Temperature	°C	60~70
Time	hr	1~3

Notes

These are only mentioned as general guidelines.