KUMHO PETROCHEMICAL

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Technical Data Sheet

HIPS(High Impact Poly Styrene)
HI 425TVL

Features High flow
Applications TV cabinet, Low pressure gas injection

Physical	Test Method	Value
Density	ASTM D792	1.03 g/cm^3
Melt Flow Index (200℃, 5kg)	ASTM D1238	13 g/10min
Mold Shrinkage	ASTM D955	0.3 ~ 0.6 %
Water absorption	ASTM D570	0.05 %

Mechanical	Test Method	Value
Tensile Strength	ASTM D638	240 kg/cm^2 (3,408) (psi)
Elongation	ASTM D638	40 %
Flexural Strength	ASTM D790	300 kg/cm^2 (4,260) (psi)
Flexural Modulus	ASTM D790	16,500 kg/cm^2 (234,300) (psi)
Izod Impact Strength(3.2mm)	ASTM D256	10 kgcm/cm (1.85) (ft·lb/in)
Rockwell Hardness(L scale)	ASTM D785	60

Thermal	Test Method	Value
Heat Deflection Temperature(18.6kgf/cm^2)	ASTM D648	76 ℃ (169) (℉)
Vicat Softening Temperature(1kg, 50℃/h)	ASTM D1525	95 ℃ (203) (℉)

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.

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Processing guide

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

Drying	Unit	Value
Temperature	℃	60~70
Time	hr	1~3

Notes

These are only mentioned as general guidelines.

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