

Edgetek™ ET7400-8001 HG NC001

High Impact Polystyrene

PolyOne Corporation

Message:

High gloss, easy flow HIPS for injection molding application

General Information			
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Molding Shrinkage (3.00 mm)	0.40 - 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	32.0	MPa	ASTM D638
Tensile Elongation (Break)	55	%	ASTM D638
Flexural Modulus ²	2000	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	82.0	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.20 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	160 - 180	°C	
Middle Temperature	210 - 240	°C	
Front Temperature	210 - 240	°C	
Mold Temperature	60.0 - 80.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		

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