

Resirene HF 777

General Purpose Polystyrene

Resirene, S.A. de C.V.

Message:

Resirene HF 777 is a medium flow GPPS that combines good processability with moderate mechanical and thermal resistance.

General Information			
Features	Good Processability		
	Medium Flow		
	Medium Heat Resistance		
Uses	Blending		
	Toys		
Agency Ratings	FDA 21 CFR 177.1640		
Processing Method	Coextrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	8.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2760	MPa	ASTM D638
Tensile Strength (Break)	38.0	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (12.7 mm)	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	75.0	°C	ASTM D648
Vicat Softening Temperature	82.0	°C	ASTM D1525
Flammability	Nominal Value		Test Method
Flame Rating (1.52 mm)	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Transmittance	90.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Rear Temperature	160 to 170	°C	
Middle Temperature	170 to 180	°C	
Front Temperature	180 to 190	°C	
Nozzle Temperature	200 to 210	°C	

Processing (Melt) Temp	170 to 230	°C
Mold Temperature	40.0	°C

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