

Resirene 6420

High Impact Polystyrene

Resirene, S.A. de C.V.

Message:

Resirene 6420 is a HIPS grade suitable for extrusion processes.

General Information			
UL YellowCard	E85100-251669		
Features	Food Contact Acceptable		
	Good Processability		
	High Impact Resistance		
	Low Flow		
Uses	Blending		
	Cups		
	Packaging		
	Sheet		
Agency Ratings	FDA 21 CFR 177.1640		
Processing Method	Extrusion		
	Injection Molding		
	Thermoforming		
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)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1820	MPa	ASTM D638
Tensile Strength (Yield)	20.0	MPa	ASTM D638
Tensile Elongation (Break)	58	%	ASTM D638
Flexural Modulus	1740	MPa	ASTM D790
Flexural Strength	33.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
3.18 mm	100	J/m	
12.7 mm	96	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	72.0	°C	ASTM D648

Vicat Softening Temperature	82.0	°C	ASTM D1525
Flammability	Nominal Value		Test Method
Flame Rating (1.52 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Processing (Melt) Temp	200 to 230	°C	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	80.0	°C	
Cylinder Zone 2 Temp.	180	°C	
Cylinder Zone 3 Temp.	190	°C	
Cylinder Zone 4 Temp.	200	°C	
Cylinder Zone 5 Temp.	210	°C	
Die Temperature	210	°C	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
 Phone: +86 13424755533
 Email: sales@su-jiao.com
 No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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