

Resirene 6470

High Impact Polystyrene

Resirene, S.A. de C.V.

Message:

Resirene 6470 is a HIPS grade suitable for extrusion processes.

General Information	
UL YellowCard	E85100-529078
Features	Fast Molding Cycle
	Good Processability
	High Gloss
	High Impact Resistance
	Low Flow
Uses	Blending
	Cups
	Packaging
	Sheet
Agency Ratings	FDA 21 CFR 177.1640
Processing Method	Extrusion
	Thermoforming

Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1660	MPa	ASTM D638
Tensile Strength (Yield)	20.0	MPa	ASTM D638
Tensile Elongation (Break)	59	%	ASTM D638
Flexural Modulus	1650	MPa	ASTM D790
Flexural Strength	29.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
3.18 mm	110	J/m	
12.7 mm	110	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
Optical	Nominal Value	Test Method
Gloss (60°)	75	ASTM D2457
Injection	Nominal Value	Unit
Rear Temperature	200 to 230	°C
Middle Temperature	200 to 230	°C
Front Temperature	200 to 230	°C
Processing (Melt) Temp	< 240	°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

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Recommended distributors for this material

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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