

HIPS 336M Technical Datasheet

1) Product Description:

PS HI 336M is high-impact polystyrene (HIPS) with very easy flow - good processability. It is a thermoplastic material designed for injection moulding. Product has a form of lens granules of diameter 2,5 to 4 mms.

2) Applications:

Injection moulding is used to produce thin-walled and shape-consuming products with the possibility of achieving high performance in processing e.g. cups, parts of boxes in the refrigerator.

The composition of the polymer meets the requirements of the Health and can therefore be used for the production of articles coming into contact with food.

3) Typical data:

Property	Test method	Unit	Value*
Melt mass-flow rate (MFR)	ISO 1133	g/10 min	11 – 13
Charpy impact strength	ISO 179/1eU	kJ/m ²	70
Charpy notched impact strength	ISO 179/1eA	kJ/m ²	5
Vicat softening temperature	50 °C/h; 50 N	°C	82
Residual styrene content	-	%	0.025
Flammability ¹⁾	UL 94	Class	HB
Moulding shrinkage	Internal	%	0.3 – 0.6
Temperature/Time of drying ²⁾ (hot-air drier)	-	°C/h	70 / 2 - 4
Temperature/Time of drying ²⁾ (drier with a molecular sieve)	-	°C/h	70 / 1
Injection moulding: Melt temperature	-	°C	180 - 260
Injection moulding: Mould temperature	-	°C	10 – 60
Extrusion: Melt temperature	-	°C	200 - 240

* Typical values not to be construed as specifications.