

VALUPAK™ RESINS

Grade: HIPS8020
Molding Grade HIPS



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.04	D792
Melt Flow (200°C/5.0 kg)	8.0 g/10 min	D1238
Mechanical		
Tensile Strength @ Yield	3,500 psi	D638
Flexural Modulus	260,000 psi	D790
Flexural Strength @ Yield	5,000 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	1.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	175 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .007 in/in	D955

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, Inc./SDR Inc. assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. *No guarantees or warranties are expressed or implied.*

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RECOMMENDED PROCESSING GUIDELINES

	Nominal Values
Drying Time and Temperature	0 - 1.0 hrs at 160 - 180°F
Suggested Max Moisture	N/A
Rear Temperature	350 – 400 °F
Middle Temperature	370 – 450 °F
Front Temperature	370 – 450 °F
Nozzle Temperature	370 – 450 °F
Processing (Melt) Temperature	370 – 450 °F
Mold Temperature	100 – 170 °F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

Rev0

Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds