

**HF 777****General Purpose Polystyrene****DESCRIPTION**

Resirene HF 777 is a medium flow GPPS that combines good processability and moderated mechanical and thermal resistance. Its excellent for the injection of complex parts who may also required good thermic and mechanical properties.

FEATURES

- Medium Flow
- Mechanical Resistance
- Easy to process
- FDA: 211 CFR 177.1640

APPLICATIONS: Injection, coextrusion, cassettes, toys, disposables, blend with SBC

PROPERTIES

	ENGLISH		S.I.		ASTM
PHYSICAL					
Specific Gravity	lb/in ³	0.04	g/cm ³	1.05	
Melt Flow Rate (200oC/5Kg)	g/10 min	8.0	g/10 min	8.0	D1238
MECHANICAL					
Tensile Strength, Break	psi	5,511	Mpa	38.0	D638
Break Elongation	%	3	%	3	D638
Tensile Modulus	psi	399,579	Mpa	2,755	D638
IMPACT RESISTANCE					
Impact Izod (0.50 in)	ft-lb/in	0.3	J/m	16.0	D256
THERMAL					
HDT @ 264 psi (unannealed)	°F	167	°C	75	D648
Vicat Temperature	°F	180	°C	82	D1525
IGNITION CHARACTERISTICS					
Flammability 0.060 in	-	HB	-	HB	UL94
OPTICAL					
Transmittance	%	90	%	90	D1003

Typical values represent average laboratory values and are intended as guides only, not as specification.

Properties designated in this standard have been determined in accordance with the current issue of the specified testing methods.

PROCESSING CONDITIONS

	°C	°F
Feeding Zone	(160-170)	(320-338)
Initial Zone	(170-180)	(338-356)
Compression Zone	(180-190)	(356-374)
Transport Zone	(200-210)	(392-410)
Pumping Zone	40	104
Temperature Profile	250	482

ADDITIONAL INFORMATION**ENVIRONMENTAL**

Resirene's materials are biological and chemically inert. If possible recycling of final parts is recommended. When disposing of HH 103, follow indications established by government laws, related norms and the material safety data sheet.

WARNING:

As most plastics materials, combustion of this material may cause hazardous fumes and gases, as well as situations that could be dangerous for health, especially in closed places. It should be noted that excessive heating or long residence times may cause degradation or yellowing

NOTE:

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