

Technical Data Sheet

HIPS(High Impact Poly Styrene)

MIB 237

Features Demoldability
Applications Yogurt beverage bottles, Disposable cups

Physical	Test Method	Value
Density	ASTM D792	1.03 g/cm ³
Melt Flow Index (200°C, 5kg)	ASTM D1238	10 g/10min
Mold Shrinkage	ASTM D955	0.3 ~ 0.6 %
Water absorption	ASTM D570	0.03 %

Mechanical	Test Method	Value
Tensile Strength	ASTM D638	250 kg/cm ² (3,550) (psi)
Elongation	ASTM D638	40 %
Flexural Strength	ASTM D790	380 kg/cm ² (5,396) (psi)
Flexural Modulus	ASTM D790	19,000 kg/cm ² (269,800) (psi)
Izod Impact Strength(3.2mm)	ASTM D256	8.0 kgcm/cm (1.48) (ft-lb/in)
Rockwell Hardness(L scale)	ASTM D785	70

Thermal	Test Method	Value
Heat Deflection Temperature(18.6kgf/cm ²)	ASTM D648	75 °C (167) (°F)
Vicat Softening Temperature(1kg, 50°C/h)	ASTM D1525	98 °C (208) (°F)

Flammability	Test Method	Value
Flame Rating - UL (1.6mm)	UL 94	HB

Notes

These are just typical properties, not specifications. Users should confirm results by their own test.

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Processing guide

Injection Guide	Unit	Value
Nozzle	°C	190~220
Front	°C	190~210
Middle	°C	180~200
Rear	°C	170~190
Hopper Throat	°C	45
Mold	°C	40~60

Drying	Unit	Value
Temperature	°C	60~70
Time	hr	1~3

Notes

These are only mentioned as general guidelines.

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