

PRODUCT DATA SHEET

SHP-1001S

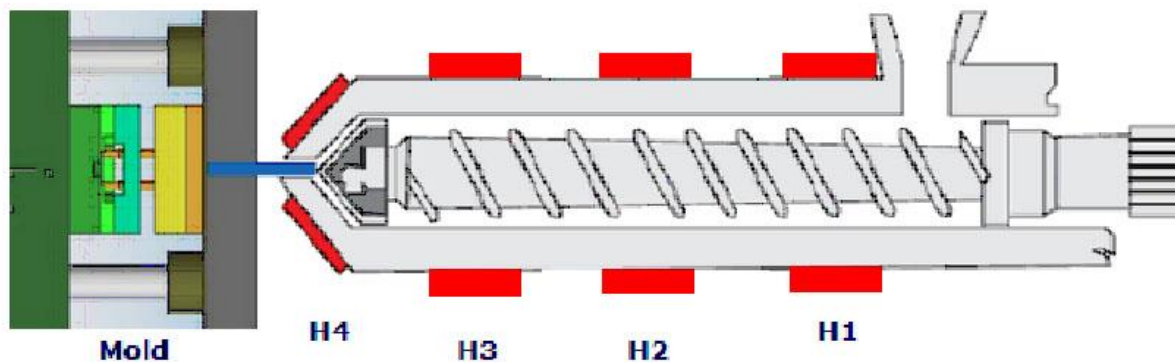
■ Description : High Impact Polystyrene (HIPS)

■ Application : Electrical and Electronics Housing

General properties	Typical value	Unit	Test method
Specific Gravity	1.05	g/cm ³	ISO 1183
Melt flow rate ,@200°C, 5kgf	7.0	g/10min	ISO 1133
Mold Shrinkage	0.3 ~ 0.6	% (3~6/1,000)	Polylex method
Mechanical properties			
Izod impact strength, 1/8"notched @+23°C	8.0	KJ /m ²	ISO 180
Tensile stress, @ yield, 50 mm/min	24	MPa	ISO 527-1
Tensile strain, @ break, 50 mm/min	40	%	ISO 527-1
Flexural strength, @yield, 10 mm/min	32	MPa	ISO 178
Flexural modulus, @yield, 10 mm/min	1,700	MPa	ISO 178
Thermal properties			
Deflection temperature @ 18.56kgf/cm ² ,4mm	72	°C	ISO 75
Vicat softening Temperature, Rate B/50	82	°C	ISO R306
Flammability			
UL-94 Recognized	1.6 2.0 3.0	mm mm mm	HB

* The above values are for the representatives

PROCESSING GUIDE of SHP-1001S



Parameter Injection Molding		Value	Unit
Drying Temperature		°C	75 ~ 85
Drying Time		Hr	3 ~ 4
Maximum moisture content		%	0.02
Melt Temperature		°C	220 ~ 230
Cylinder Temperature	H4	°C	220 ~ 230
	H3	°C	220 ~ 230
	H2	°C	220 ~ 230
	H1	°C	210 ~ 220
Mold Temperature		°C	40 ~ 80
Back Pressure		MPa	0.3 ~ 0.7
Screw rotating speed		rpm	40 ~ 80