

Technical Data Sheet

PCR HIPS Regranulate White

Product Code: 000121

Recycled Content: 100 % PCR (post-consumer)

Product Description:

000121 PCR HIPS Regranulate White comes from post-consumer recycled materials in Asia and is suitable for injection moulding applications. The material is GRS certified.



Physical Property	Value	Units	Test Standard	Test Condition
Tensile Strength	28	MPa	ISO 527-2	50mm/min
Tensile Strain at Break	20	%	ISO 527-2	50mm/min
Flexural Strength	45	MPa	ISO 178	2mm/min
Flexural Modulus	2100	MPa	ISO 178	2mm/min
Izod Notched Impact Strength	8	KJ/m2	ISO 180	23°C
Melt Mass-flow Rate(MFR)	5	g/10min	ISO 1133-1	200°C, 5kg
Density	1.05	g/cm3	ISO 1183-1	23°C

Typical Processing Conditions				
Processing Parameter	Condition	Optimum	Range	Unit
Melt Temp.		200	200 - 240	°C
Barrel Zone Temp.	Rear	190	180 - 200	°C
Barrel Zone Temp.	Center	200	190 - 205	°C
Barrel Zone Temp.	Front	205	200 - 220	°C

Typical Processing Conditions				
Processing Parameter	Condition	Optimum	Range	Unit
Mold Temp.		50	30 - 60	°C
Processing Temp. Upper Limit		240		°C
Injection Speed		Slow to Moderate		
Back Pressure			200 - 800	KPa
Pre-dry Requirements			80 - 90°C, 2 - 4h	

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