



# Resirene® HF 777

Resirene, S.A. de C.V. - General Purpose Polystyrene

## General Information

### Product Description

#### FEATURES

- Medium Flow
- Easy to Process
- High Productivity
- Ideal for Thin Wall and Complex Parts
- FDA Rating: 21 CFR 177.1640

#### APPLICATIONS

- Injection Molding
- Coextrusion
- Single Service Cutlery and Drinkware
- Toys

### General

Features	• Fast Molding Cycle	• Good Processability	• Medium Flow
Uses	• Kitchenware	• Thin-walled Parts	• Toys
Agency Ratings	• FDA 21 CFR 177.1640		
Processing Method	• Coextrusion	• Injection Molding	

## Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	8.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	512000	psi	ASTM D638
Tensile Strength (Break)	5950	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	172	°F	ASTM D648
Vicat Softening Temperature	192	°F	ASTM D1525
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Light Transmittance	90.0	%	ASTM D1003

## Processing Information

Injection	Nominal Value	Unit
Rear Temperature	392 to 410	°F
Middle Temperature	410 to 428	°F
Front Temperature	428 to 446	°F
Nozzle Temperature	446 to 464	°F