

		Total Petrochemicals HIPS			
		4440	6541	3630	3450
Melt Temperature	minimum	220	210	200	220
	maximum	270	260	250	270
Typical Temperature Profile hopper-->nozzle		220 --> 250	210 --> 240	200 --> 230	220 --> 250
Injection Pressure		depend on melt T°, Inj speed, design of the molded object,...			
Injection Speed		Profile to adap following size and design of moulded part			
Back Pressure		to adap (<15 bar)			
Tool Temperature		20 to 60°C			
Drying		not necessary but to avoid moisture -->1h at 80°C			
Observations		Well adapted to gas assisted injection		High fluidity	Heat resistant

