

# VALUPAK™ Resins



Grade: HIPS8020  
Molding Grade HIPS

326 Jack Burlingame Dr, Millwood, WV 25262 USA  
Phone: 304.273.0352, Fax: 304.273.0355

## Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.04	D792
Melt Flow (200 °C/5.0 kg)	8.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Strength at Yield	3,500 psi	D638
Flexural Modulus	260,000 psi	D790
Flexural Strength at Yield	5,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	1.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	175 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 - .007 in/in	D955

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, Inc./SDR Inc. assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. **No guarantees or warranties are expressed or implied.**

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## Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	0 - 1.0 hr at 160 - 180 °F
Suggested Max Moisture	N/A
Rear Temperature	350 - 400 °F
Middle Temperature	370 - 450 °F
Front Temperature	370 - 450 °F
Nozzle Temperature	370 - 450 °F
Processing (melt) Temperature	370 - 450 °F
Mold Temperature	100 - 170 °F
Back Pressure	25 - 100 psi
Screw Speed	25 - 75 rpm

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

**Your Competitive Advantage in an Ever Changing Market!**

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