

## HiFill® PPSU/PC

Techmer Polymer Modifiers - Polysulfone + PC

### Product Description

PSUM116599

### General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10900	psi	ASTM D638
Tensile Elongation (Yield)	7.0	%	ASTM D638
Tensile Elongation (Break)	80	%	ASTM D638
Flexural Modulus	345000	psi	ASTM D790
Flexural Strength	14500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	12	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	403	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	367	°F	ASTM D648

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	600 to 630	°F
Middle Temperature	610 to 640	°F
Front Temperature	610 to 640	°F
Nozzle Temperature	620 to 650	°F
Processing (Melt) Temp	610 to 640	°F
Mold Temperature	300 to 350	°F
Back Pressure	0.00 to 100	psi

