HiFill® PES/PC

Techmer Polymer Modifiers - *Polysulfone + PC*

Product Description	
PSUM116601	
General	
Material Status	• Commercial: Active
Availability	• North America
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	82.7	MPa	ASTM D638
Tensile Strength (Break)	68.9	MPa	ASTM D638
Tensile Elongation (Yield)	6.9	%	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	2720	MPa	ASTM D790
Flexural Strength	112	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.18 mm)	80	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (0.45 MPa, Unannealed)	204	°C	ASTM D648
Deflection Temperature Under Load (1.8 MPa, Unannealed)	186	°C	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	2.0 to 3.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	316 to 332	°C
Middle Temperature	321 to 338	°C
Front Temperature	321 to 338	°C
Nozzle Temperature	327 to 343	°C
Processing (Melt) Temp	321 to 338	°C
Mold Temperature	149 to 177	°C
Back Pressure	0.00 to 0.689	MPa

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