

HiFill® J-1500/40 BK

Techmer Polymer Modifiers - Polysulfone

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.55	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60 to 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11700	MPa	ASTM D638
Tensile Strength (Yield)	121	MPa	ASTM D638
Tensile Strength (Break)	117	MPa	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	12400	MPa	ASTM D790
Flexural Strength	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	53	J/m	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	335 to 363	°C
Middle Temperature	343 to 371	°C
Front Temperature	349 to 377	°C
Nozzle Temperature	354 to 382	°C
Processing (Melt) Temp	343 to 379	°C
Mold Temperature	135 to 177	°C
Injection Rate	Moderate	
Back Pressure	0.00 to 0.345	MPa
Screw Speed	Slow-Moderate	

