

HiFill® PES GF10 BN202

 Techmer Polymer Modifiers - *Polyethersulfone*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.46		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	611000	psi	ASTM D638
Tensile Strength (Yield)	14000	psi	ASTM D638
Tensile Elongation (Break)	6.1	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.1	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	300	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	660 to 720	°F
Middle Temperature	660 to 720	°F
Front Temperature	660 to 720	°F
Nozzle Temperature	660 to 720	°F
Processing (Melt) Temp	670 to 730	°F
Mold Temperature	250 to 320	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 75.0	psi
Screw Speed	Slow	

