

HiFill® PES 2010 LE WT398

 Techmer Polymer Modifiers - *Polyethersulfone*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• White
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.44		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Elongation (Break)	7.0	%	ASTM D638
Flexural Modulus	380000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	290	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	550 to 600	°F
Middle Temperature	575 to 625	°F
Front Temperature	575 to 635	°F
Nozzle Temperature	575 to 635	°F
Processing (Melt) Temp	639 to 730	°F
Mold Temperature	280 to 384	°F
Injection Rate	Slow	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow	

