

**HiFill® PES GF15 RD187 A**

 Techmer Polymer Modifiers - *Polyethersulfone*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Appearance	• Red
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.45		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	750000	psi	ASTM D638
Tensile Strength (Yield)	14500	psi	ASTM D638
Tensile Strength (Break)	14000	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft-lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	275	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	660 to 700	°F
Middle Temperature	670 to 710	°F
Front Temperature	680 to 720	°F
Nozzle Temperature	690 to 730	°F
Processing (Melt) Temp	660 to 730	°F
Mold Temperature	300 to 375	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

