

**HiFill® PPSU 5100 BL333**

 Techmer Polymer Modifiers - *Polyphenylsulfone*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Blue</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.040 to 0.060	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	340000	psi	ASTM D638
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Break)	75	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	11	ft·lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	300	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	660 to 690	°F
Middle Temperature	670 to 700	°F
Front Temperature	680 to 710	°F
Nozzle Temperature	690 to 725	°F
Processing (Melt) Temp	670 to 730	°F
Mold Temperature	300 to 350	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

