HiFill® PPSU 5500 BSF06 LE BN102

Techmer Polymer Modifiers - *Polyphenylsulfone*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Features	• Low Extractables
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.40		ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	15	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	• 10700 • 10700	psi	ASTM D638
Tensile Strength (Break)	8600	psi	ASTM D638
Tensile Elongation (Break)	42	%	ASTM D638
Flexural Modulus	• 406000 • 410000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	• 2.8 • 2.8	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	387	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	300	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	640 to 730	°F
Middle Temperature	640 to 730	°F
Front Temperature	640 to 730	°F
Nozzle Temperature	640 to 730	°F
Processing (Melt) Temp	680 to 735	°F
Mold Temperature	280 to 325	°F
Injection Rate	Slow	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	