

**HiFill® PPSU HF CL**

 Techmer Polymer Modifiers - *Polyphenylsulfone*
**General Information**
**General**

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

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.29		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	31	g/10 min	ASTM D1238
Water Absorption (24 hr)	0.30	%	ASTM D570
<b>Mechanical</b>			
Tensile Modulus	320000	psi	ASTM D638
Tensile Strength (Yield)	9500	psi	ASTM D638
Tensile Elongation (Break)	7.5	%	ASTM D638
Flexural Modulus	355000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (0.125 in)	2.0	ft-lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	385	°F	ASTM D648

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	275	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	650 to 700	°F
Middle Temperature	660 to 710	°F
Front Temperature	670 to 720	°F
Nozzle Temperature	680 to 730	°F
Processing (Melt) Temp	660 to 730	°F
Mold Temperature	250 to 350	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

