

**HiFill® PPSU A1 0200 B LE**

 Techmer Polymer Modifiers - *Polyphenylsulfone*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Features	• High Density      • Low Extractables
Agency Ratings	• FDA
Appearance	• Colors Available      • Opaque
Forms	• Pellets
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	2.00		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	440000	psi	ASTM D790
Flexural Strength	15800	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	120		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	428	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	408	°F	ASTM D648
CLTE - Flow	4.0E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	480	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating (0.12 in)	V-0		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	320	°F
Drying Time	3.0	hr
Rear Temperature	675 to 735	°F
Middle Temperature	675 to 735	°F
Front Temperature	675 to 735	°F
Processing (Melt) Temp	650 to 750	°F
Mold Temperature	230 to 300	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 100	rpm

