

HiFill® PPSU 3010 LE GN165

Techmer Polymer Modifiers - *Polyphenylsulfone*

General Information

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10800	psi	ASTM D638
Tensile Elongation (Break)	55	%	ASTM D638

Processing Information

Injection	Nominal Value	Unit
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 735	°F
Mold Temperature	200 to 300	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

