

HiFill® PPSU GF25 LE

 Techmer Polymer Modifiers - *Polyphenylsulfone*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Features	• Low Extractables
Appearance	• Colors Available
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.43		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	17100	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	24900	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	2.0	ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	420	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	420	°F	ASTM D648
CLTE - Flow	2.0E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	470	V/mil	ASTM D149
Flammability			
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

