

## HiFill® PPSU 3010 LE BL277

Techmer Polymer Modifiers - *Polyphenylsulfone*

### General Information

#### General

|                   |                      |
|-------------------|----------------------|
| Material Status   | • Commercial: Active |
| Availability      | • North America      |
| Appearance        | • Blue               |
| Processing Method | • Injection Molding  |

### Properties <sup>1</sup>

| Physical                            | Nominal Value    | Unit  | Test Method |
|-------------------------------------|------------------|-------|-------------|
| Density / Specific Gravity          | 1.30             |       | 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)            | 10600            | 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      |      |

