

HiFill® PPSU 4000 CL OR072

 Techmer Polymer Modifiers - *Polyphenylsulfone*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Orange
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	15 to 25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	320000	psi	ASTM D638
Tensile Strength (Yield)	10000	psi	ASTM D638
Tensile Strength (Break)	8500	psi	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	12	ft·lb/in	ASTM D256

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	250 to 350	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

