

HiFill® TECASON P GN115

 Techmer Polymer Modifiers - *Polyphenylsulfone*
General Information
General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.32		ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	16	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Elongation (Break)	46	%	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	300	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	660 to 690	°F
Middle Temperature	670 to 700	°F
Front Temperature	680 to 710	°F
Nozzle Temperature	690 to 725	°F
Processing (Melt) Temp	670 to 730	°F
Mold Temperature	300 to 350	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

