

**HiFill® PPSU 5500 BSF06 LE BK085**

 Techmer Polymer Modifiers - *Polyphenylsulfone*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Features	<ul style="list-style-type: none"> <li>Low Extractables</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Black</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	15	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10200	psi	ASTM D638
Tensile Strength (Break)	8500	psi	ASTM D638
Tensile Elongation (Break)	41	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	4.7	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	300	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	640 to 730	°F
Middle Temperature	640 to 730	°F
Front Temperature	640 to 730	°F
Nozzle Temperature	640 to 730	°F
Processing (Melt) Temp	680 to 735	°F
Mold Temperature	280 to 325	°F
Injection Rate	Slow	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	

