

**HiFill® PSU 1700 MR05 BK094**

 Techmer Polymer Modifiers - *Polysulfone*
**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>      |
| 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          | 1.24             |          | ASTM D792   |
| Molding Shrinkage - Flow (0.125 in) | 6.0E-3 to 8.0E-3 | in/in    | ASTM D955   |
| Mechanical                          | Nominal Value    | Unit     | Test Method |
| Tensile Modulus                     | 350000           | psi      | ASTM D638   |
| Tensile Strength (Yield)            | 10500            | psi      | ASTM D638   |
| Tensile Strength (Break)            | 8000             | psi      | ASTM D638   |
| Tensile Elongation (Break)          | 12               | %        | ASTM D638   |
| Impact                              | Nominal Value    | Unit     | Test Method |
| Notched Izod Impact (0.125 in)      | 0.90             | 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       | 640 to 680    | °F   |
| Middle Temperature     | 650 to 690    | °F   |
| Front Temperature      | 660 to 700    | °F   |
| Nozzle Temperature     | 670 to 710    | °F   |
| Processing (Melt) Temp | 650 to 710    | °F   |
| Mold Temperature       | 250 to 325    | °F   |
| Injection Rate         | Moderate      |      |
| Back Pressure          | 50.0 to 100   | psi  |
| Screw Speed            | Moderate-Fast |      |

