

**HiFill® PSU 2010 LE BL355**

 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>Blue</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)	5.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	360000	psi	ASTM D638
Tensile Strength (Yield)	10000	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.1	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	635 to 685	°F
Middle Temperature	650 to 700	°F
Front Temperature	660 to 710	°F
Nozzle Temperature	670 to 720	°F
Processing (Melt) Temp	625 to 725	°F
Mold Temperature	275 to 350	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Medim-Fast	

