

HiFill® J-1500/40 BK

 Techmer Polymer Modifiers - *Polysulfone*
General Information
General

| | |
|------------------------|--|
| Material Status | <ul style="list-style-type: none"> Commercial: Active |
| Availability | <ul style="list-style-type: none"> North America |
| Filler / Reinforcement | <ul style="list-style-type: none"> Glass Fiber |
| Appearance | <ul style="list-style-type: none"> Black |
| Processing Method | <ul style="list-style-type: none"> Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|-------------------------------------|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.55 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 6.0E-3 to 9.0E-3 | in/in | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 1.70E+6 | psi | ASTM D638 |
| Tensile Strength (Yield) | 17500 | psi | ASTM D638 |
| Tensile Strength (Break) | 17000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 1.0 | % | ASTM D638 |
| Flexural Modulus | 1.80E+6 | psi | ASTM D790 |
| Flexural Strength | 25000 | psi | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 1.0 | 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 | 650 to 715 | °F |
| Mold Temperature | 275 to 350 | °F |
| Injection Rate | Moderate | |
| Back Pressure | 0.00 to 50.0 | psi |
| Screw Speed | Slow-Moderate | |

