

HiFill® PSU 1700 LE NAT

 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
Appearance	<ul style="list-style-type: none"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		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)	9500	psi	ASTM D638
Tensile Strength (Break)	9000	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
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	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	25.0 to 75.0	psi
Screw Speed	Moderate-Fast	

