

**HiFill® PSU 2611 LE WT401**

 Techmer Polymer Modifiers - *Polysulfone*
**General Information**

General	
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>White</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	1.27		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	410000	psi	ASTM D638
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	70	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	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	640 to 680	°F
Middle Temperature	650 to 690	°F
Front Temperature	660 to 700	°F
Nozzle Temperature	660 to 700	°F
Processing (Melt) Temp	650 to 700	°F
Mold Temperature	275 to 350	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate-Fast	

