

HiFill® PSU GF30 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, 30% Filler by Weight
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	1.46		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	15900	psi	ASTM D638
Tensile Elongation (Break)	2.4	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.3	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 710	°F
Processing (Melt) Temp	640 to 725	°F
Mold Temperature	275 to 350	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate-Fast	

