

HiFill® PSU 2010 LE WT400 almond

 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
Features	<ul style="list-style-type: none"> Low Extractables
Appearance	<ul style="list-style-type: none"> White
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Melt Mass-Flow Rate (MFR) (343°C/2.16 kg)	14	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	379000	psi	ASTM D638
Tensile Strength (Yield)	10800	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	73	%	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	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 325	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 150	psi
Screw Speed	Moderate-Fast	

