

HiFill® PSU 3010 LE WT286

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.25		ASTM D792
Melt Mass-Flow Rate (MFR) (343°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Elongation (Break)	87	%	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	275	°F
Drying Time	2.0 to 3.0	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 715	°F
Mold Temperature	250 to 350	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

