

HiFill® PEEK 0169 S8 LE BL357

 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"> Blue

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.72		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	720000	psi	ASTM D638
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	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	690 to 730	°F
Middle Temperature	700 to 740	°F
Front Temperature	710 to 750	°F
Nozzle Temperature	715 to 755	°F
Processing (Melt) Temp	700 to 760	°F
Mold Temperature	250 to 350	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

