

HiFill® PSU 2010 GF30 LE WT375

 Techmer Polymer Modifiers - *Polysulfone*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• White

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.50E+6	psi	ASTM D638
Tensile Strength (Yield)	15000	psi	ASTM D638
Tensile Strength (Break)	15500	psi	ASTM D638
Tensile Elongation (Break)	1.7	%	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	4.0	hr
Rear Temperature	635 to 686	°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	

