

**HiFill® Thoren PSU GF20 BL377**

 Techmer Polymer Modifiers - *Polysulfone*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.37		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength (Yield)	11800	psi	ASTM D638
Tensile Elongation (Break)	2.6	%	ASTM D638

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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	

