

HiFill® PES/PC

 Techmer Polymer Modifiers - *Polysulfone + PC*
General Information
Product Description

PSUM116601

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.30		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Mechanical			
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Strength (Break)	10000	psi	ASTM D638
Tensile Elongation (Yield)	6.9	%	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	394000	psi	ASTM D790
Flexural Strength	16200	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.5	ft-lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	400	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	367	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	600 to 630	°F
Middle Temperature	610 to 640	°F
Front Temperature	610 to 640	°F
Nozzle Temperature	620 to 650	°F
Processing (Melt) Temp	610 to 640	°F
Mold Temperature	300 to 350	°F
Back Pressure	0.00 to 100	psi

