Wednesday, May 13, 2026

HiFill® PPSU 4000 CL OR072

Techmer Polymer Modifiers - *Polyphenylsulfone*

Units SI

Action **Legend (Open)**

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Appearance	• Orange
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	15 to 25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.70 to 0.90	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2210	MPa	ASTM D638
Tensile Strength (Yield)	68.9	MPa	ASTM D638
Tensile Strength (Break)	58.6	MPa	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	640	J/m	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	135	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	343 to 371	°C
Middle Temperature	349 to 377	°C
Front Temperature	354 to 382	°C
Nozzle Temperature	360 to 388	°C
Processing (Melt) Temp	349 to 391	°C
Mold Temperature	121 to 177	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.172 to 0.517	MPa
Screw Speed	Moderate	

Notes

[1] Typical properties: these are not to be construed as specifications.

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