

Product Information

Nov 2019

Ultrason® P 2010 **Polyphenylsulfone (PPSU)**


Product Description

Ultrason P 2010 is an unreinforced, medium viscosity injection molding PPSU grade

PHYSICAL	ISO Test Method	Property Value
Density, g/cm ³	1183	1.29
Moisture, % (50% RH)	62	0.6
RHEOLOGICAL	ISO Test Method	Property Value
Melt Volume Rate (360 C/10 Kg), cc/10min.	1133	80
MECHANICAL	ISO Test Method	Property Value
Tensile Modulus, MPa 23C	527	2,250
Tensile stress at yield, MPa 23C	527	74
Tensile strain at yield, % 23C	527	7.8
IMPACT	ISO Test Method	Property Value
Izod Notched Impact, kJ/m ² -30C	180	25
23C		50
Charpy Notched, kJ/m ² -30C	179	30
23C		65
Charpy Unnotched, kJ/m ² -30C	179	N
23C		N
THERMAL	ISO Test Method	Property Value
HDT A, C	75	195

Processing Guidelines
Material Handling

Max. Water content: 0.02%

Ultrason pellets can absorb moisture very rapidly and must be dried before processing. A vacuum or dry air oven operating at 130-150C (266-302F) is recommended. Circulating air ovens are unsuitable. Drying time is dependent on moisture level, however the materials must be dried at least 4 hours. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile

Melt Temperature 350-390C (662-734F)

Mold Temperature 140-180C (284-356F)

Injection and Packing Pressure 35-125 bar (500-1500 psi)

Mold Temperatures

BASF Corporation
Engineering Plastics
1609 Biddle Avenue
Wyandotte, MI 48192

General Information: 800-BC-RESIN
Technical Assistance: 800-527-TECH (734-324-5150)
Web address: <http://www.plasticsportal.com/usa>

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Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off.

Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas.

Pressures

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate.

Note

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