

HiFill® J-50/10 BK223

Techmer Polymer Modifiers - Polycarbonate

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	
Moisture (284°F)	0.080	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Elongation (Break)	6.6	%	ASTM D638
Flexural Modulus	560000	psi	ASTM D790
Flexural Strength	18700	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.4	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	510 to 565	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

