

HiFill® J-50/20/A BK

Techmer Polymer Modifiers - *Polycarbonate*

General

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

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	14100	psi	ISO 527-2
Flexural Modulus	870000	psi	ISO 178
Flexural Stress	22300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (0.125 in)	4.5	ft·lb/in ²	ISO 180

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	

