

HiFill® J-50/20 BK223

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)	14500	psi	ISO 527-2
Flexural Modulus	902000	psi	ISO 178
Flexural Stress	23300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (0.125 in)	4.9	ft·lb/in ²	ISO 180
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-2		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	520 to 560	°F
Front Temperature	540 to 580	°F
Nozzle Temperature	530 to 575	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	150 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

