

HiFill® J-50/20/RG RD8664

Techmer Polymer Modifiers - Polycarbonate

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• Red
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.32		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	13800	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	850000	psi	ASTM D790
Flexural Strength	21000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	540 to 580	°F
Middle Temperature	550 to 590	°F
Front Temperature	560 to 600	°F
Nozzle Temperature	570 to 610	°F
Processing (Melt) Temp	550 to 610	°F
Mold Temperature	170 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

