

## HiFill FR® PC-50/EC/VO BK

Techmer Polymer Modifiers - Polycarbonate

### General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.32	g/cm <sup>3</sup>	
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.7	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	8.79E+6	psi	ISO 527-2
Tensile Strain (Break)	20	%	ISO 527-2
Flexural Modulus	406000	psi	ISO 178
Flexural Stress	14000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (0.125 in)	2.3	ft·lb/in <sup>2</sup>	ISO 180
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+6	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	460 to 515	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

