HiTerra® PC FR 2450 3DP

Techmer Polymer Modifiers - *Polycarbonate*

Product Description

HiTerra® PC FR 2450 3DP is a specially formulated, high clarity, flame retardant, and compounded thermoplastic material designed for general purpose additive manufacturing applications. This product has been optimized for maximum printability in additive manufacturing.

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Filler
Additive	• Flame Retardant
Features	• Flame Retardant
Uses	• Additive Manufacturing (3D Printing)

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	10000	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	600000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	1.5	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	266	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.12 in)	V-2		UL 94

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	1.0 to 5.0	hr
Cylinder Zone 1 Temp.	490 to 520	°F
Cylinder Zone 2 Temp.	520 to 540	°F
Cylinder Zone 3 Temp.	520 to 540	°F
Cylinder Zone 4 Temp.	540 to 570	°F
Melt Temperature	560 to 620	°F
Die Temperature	540 to 570	°F

Extrusion Notes

If drying for longer than 3 hours, recommend reducing the temperature to 120°F in a dessiccant dryer to avoid degradaton of the material.