

## HiFill® PC GF/GM20 BK

Techmer Polymer Modifiers - *Polycarbonate*

### General

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

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	600000	psi	ASTM D638
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Elongation (Break)	4.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.3	ft-lb/in	ASTM D256

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	550 to 600	°F
Middle Temperature	560 to 600	°F
Front Temperature	570 to 600	°F
Nozzle Temperature	570 to 600	°F
Processing (Melt) Temp	550 to 625	°F
Mold Temperature	175 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

