

**HiFill® PC/PBT IM 6702 BN174**

Techmer Polymer Modifiers - Polycarbonate

**General**

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Brown
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.24		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	40	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	320000	psi	ASTM D638
Tensile Strength (Yield)	6500	psi	ASTM D638
Tensile Strength (Break)	5000	psi	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	11	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	485 to 525	°F
Processing (Melt) Temp	465 to 525	°F
Mold Temperature	125 to 175	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

