

HiTerra® rPC FR 2472 3DP

Techmer Polymer Modifiers - Polycarbonate

Product Description

HiTerra® PC FR 2472 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	• Glass Fiber
Recycled Content	• Yes
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.	450 to 480	°F
Cylinder Zone 2 Temp.	460 to 490	°F
Cylinder Zone 3 Temp.	460 to 490	°F
Cylinder Zone 4 Temp.	470 to 520	°F
Melt Temperature	470 to 520	°F
Die Temperature	470 to 520	°F

Extrusion Notes

If drying for longer than 5 hours, recommend reducing the temperature to 120°F in a desiccant dryer to avoid degradation of the material.

