

HiFill® PC / ABS 830 GF10

Techmer Polymer Modifiers - Polycarbonate

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.20		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical			
Tensile Strength (Break)	8900	psi	ASTM D638
Tensile Elongation (Break)	4.5	%	ASTM D638
Flexural Modulus	590000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
Impact			
Notched Izod Impact	1.6	ft·lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	119		ASTM D785
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	240	°F	ASTM D648
CLTE - Flow	2.3E-5	in/in/°F	ASTM D696
Flammability			
Flame Rating	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	575 to 600	°F
Middle Temperature	600 to 630	°F
Front Temperature	590 to 620	°F
Nozzle Temperature	590 to 620	°F
Processing (Melt) Temp	580 to 620	°F
Mold Temperature	160 to 190	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 100	psi

Injection Notes

Screw Speed: Medium
 Recommendations for Molding and Tool Conditions: Well vented mold
 Moisture Content, as received: Product is packaged at 0.2% or less.

