

HiTerra® PC 2416 3DP

Techmer Polymer Modifiers - *Polycarbonate*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber
Uses	• Additive Manufacturing (3D Printing)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	800000	psi	ASTM D638
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	750000	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	200	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	HB		UL 94

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	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	540 to 570	°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 desiccant dryer to avoid degradation of the material.

