

HiFill® PC/ABS GF10 NAT

Techmer Polymer Modifiers - Polycarbonate + ABS

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	590000	psi	ASTM D638
Tensile Strength (Yield)	11200	psi	ASTM D638
Tensile Strength (Break)	10900	psi	ASTM D638
Tensile Elongation (Break)	4.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.3	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	520 to 560	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

