

HiFill® PC/ABS T85 UV Black

Techmer Polymer Modifiers - *Polycarbonate + ABS*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• UV Stabilizer
Features	• UV Stabilized
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20 to 35	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	330000	psi	ASTM D638
Tensile Strength (Yield)	7300	psi	ASTM D638
Tensile Strength (Break)	7000	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	10	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	225	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	490 to 530	°F
Mold Temperature	150 to 200	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

