

HiFill® PC/ABS 8100 UV GN138

Techmer Polymer Modifiers - Polycarbonate + ABS

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Additive	<ul style="list-style-type: none"> UV Stabilizer
Features	<ul style="list-style-type: none"> UV Stabilized
Appearance	<ul style="list-style-type: none"> Green
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	340000	psi	ASTM D638
Tensile Strength (Yield)	6000	psi	ASTM D638
Tensile Strength (Break)	5500	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	410000	psi	ASTM D790
Flexural Strength	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.8	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	520 to 555	°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	

