

HiFill® PC/ABS 830 GY204

Techmer Polymer Modifiers - Polycarbonate + ABS

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Grey
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8300	psi	ASTM D638
Tensile Strength (Break)	6300	psi	ASTM D638
Tensile Elongation (Break)	22	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	6.5	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	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	490 to 530	°F
Processing (Melt) Temp	465 to 525	°F
Mold Temperature	125 to 175	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

