

HiFill® PC/ABS GF20 NAT

Techmer Polymer Modifiers - *Polycarbonate + ABS*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.20E+6	psi	ASTM D638
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Elongation (Break)	3.3	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	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	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	510 to 570	°F
Mold Temperature	150 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

