

## HiFill FR® PC/ABS FR NH

Techmer Polymer Modifiers - Polycarbonate + ABS

### Product Description

PAM114434

### General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant      • Halogen Free
Appearance	• Colors Available
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	490000	psi	ASTM D638
Tensile Strength (Yield)	7600	psi	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Flexural Modulus	440000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	11	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	ASTM D257
Volume Resistivity	> 1.0E+15	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	465 to 515	°F
Middle Temperature	475 to 525	°F
Front Temperature	485 to 535	°F
Nozzle Temperature	495 to 545	°F
Mold Temperature	50 to 225	°F
Extrusion	Nominal Value	Unit
Melt Temperature	485 to 535	°F

