

HiFill® PC/ABS 830 WT373

Techmer Polymer Modifiers - Polycarbonate + ABS

General

| | |
|-------------------|----------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Appearance | • White |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--------------------------------|---------------|----------|-------------|
| Density / Specific Gravity | 1.15 | | ASTM D792 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 373000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 8000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 50 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 9.6 | 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 | |

