

HiFill FR® PC/ABS 850 FR1510-02 GY204

Techmer Polymer Modifiers - Polycarbonate + ABS

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Grey
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	410000	psi	ASTM D638
Tensile Strength (Yield)	9600	psi	ASTM D638
Tensile Strength (Break)	6800	psi	ASTM D638
Tensile Elongation (Break)	28	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.7	ft·lb/in	ASTM D256
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 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	515 to 555	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	150 to 225	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

