

## HiFill® PC/PBT IM 5220 LE

Techmer Polymer Modifiers - Polycarbonate + PBT

### General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified • Low Extractables
Appearance	• Colors Available
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength	7600	psi	ASTM D638
Tensile Elongation (Yield)	130	%	ASTM D638
Flexural Modulus	290000	psi	ASTM D790
Flexural Strength	12200	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	13	ft-lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	225	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
<b>Flammability</b>			
Flame Rating (0.06 in)	HB		UL 94

### Processing Information

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	210	°F
Drying Time	4.0	hr
Rear Temperature	460 to 510	°F
Middle Temperature	460 to 510	°F
Front Temperature	460 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	130 to 200	°F
Back Pressure	25.0 to 60.0	psi
Screw Speed	30 to 60	rpm

