

## HiFill® PC/PBT IM 5720 UV BK

Techmer Polymer Modifiers - Polycarbonate + PBT

### General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier      • UV Stabilizer
Features	• Impact Modified      • UV Stabilized
Appearance	• Black
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	320000	psi	ASTM D638
Tensile Strength (Yield)	7800	psi	ASTM D638
Tensile Strength (Break)	7800	psi	ASTM D638
Tensile Elongation (Break)	80	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	11	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	

