

HiFill® PC/PBT IM 5240 BK106

Techmer Polymer Modifiers - Polycarbonate + PBT

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	75	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	15	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
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
Nozzle Temperature	460 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

