

HiFill® PC/PET 2230 PK029

Techmer Polymer Modifiers - Polycarbonate + PET

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Pink
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	18	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	331000	psi	ASTM D638
Tensile Strength (Yield)	8600	psi	ASTM D638
Tensile Strength (Break)	7900	psi	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	13	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	510 to 565	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

