

HiFill FR® PC/ASA FR1520 UV GY335 A

Techmer Polymer Modifiers - Polycarbonate + ASA

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant • UV Stabilizer
Features	• Flame Retardant • UV Stabilized
Appearance	• Grey
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)	8.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Strength (Break)	7000	psi	ASTM D638
Tensile Elongation (Break)	> 20	%	ASTM D638
Flexural Modulus	400000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	7.0	ft-lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 550	°F
Middle Temperature	520 to 560	°F
Front Temperature	530 to 570	°F
Nozzle Temperature	535 to 575	°F
Processing (Melt) Temp	515 to 575	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

