

## HiFill® PC/PET 2230 YL122

Techmer Polymer Modifiers - Polycarbonate + PET

### General

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

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	11	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8100	psi	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	2.0 to 3.0	hr
Rear Temperature	490 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	510 to 540	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	495 to 550	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

