

## HiFill® PC / PET 2230

Techmer Polymer Modifiers - Polycarbonate + PBT

### General

|                   |                            |
|-------------------|----------------------------|
| Material Status   | • Commercial: Active       |
| Availability      | • North America            |
| Additive          | • Impact Modifier          |
| Features          | • Impact Modified          |
| Appearance        | • Black • Colors Available |
| Processing Method | • Injection Molding        |

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

| Physical  | Nominal Value | Unit     | Test Method |
|---|---------------|----------|-------------|
| Density / Specific Gravity                              | 1.22          |          | ASTM D792   |
| Melt Mass-Flow Rate (MFR)                               |               |          | ASTM D1238  |
| 265°C/2.16 kg   | 6.5           | g/10 min |             |
| 300°C/1.2 kg  | 14            | g/10 min |             |
| Molding Shrinkage - Flow (0.125 in)                     | 8.0E-3        | in/in    | ASTM D955   |
| Water Absorption (24 hr)                                | 0.17          | %        | ASTM D570   |
| Mechanical  | Nominal Value | Unit     | Test Method |
| Tensile Strength  | 7000          | psi      | ASTM D638   |
| Tensile Elongation (Break)                              | 70            | %        | ASTM D638   |
| Flexural Modulus  | 320000        | psi      | ASTM D790   |
| Flexural Strength                                       | 13000         | psi      | ASTM D790   |
| Impact  | Nominal Value | Unit     | Test Method |
| Notched Izod Impact (73°F, 0.125 in)                    | 15            | ft-lb/in | ASTM D256   |
| Hardness  | Nominal Value | Unit     | Test Method |
| Rockwell Hardness (R-Scale)                             | 117           |          | ASTM D785   |
| Thermal   | Nominal Value | Unit     | Test Method |
| Deflection Temperature Under Load (264 psi, Unannealed) | 250           | °F       | ASTM D648   |
| CLTE - Flow   | 3.5E-5        | in/in/°F | ASTM D696   |
| Electrical  | Nominal Value | Unit     | Test Method |
| Volume Resistivity                                      | 7.0E+15       | ohms·cm  | ASTM D257   |
| Dielectric Strength                                     | 600           | V/mil    | ASTM D149   |
| Flammability  | Nominal Value | Unit     | Test Method |
| Flame Rating (0.06 in)                                  | HB            |          | UL 94       |

### 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   |
| Processing (Melt) Temp | 460 to 510    | °F   |
| Mold Temperature       | 130 to 200    | °F   |
| Back Pressure          | 25.0 to 60.0  | psi  |
| Screw Speed            | 30 to 60      | rpm  |

