

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

ASTM & ISO Properties ¹

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

