

**HiFill® J-50/20 BK223**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Black</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Stress (Yield)	14500	psi	ISO 527-2
Flexural Modulus	902000	psi	ISO 178
Flexural Stress	23300	psi	ISO 178
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact Strength (0.125 in)	4.9	ft·lb/in <sup>2</sup>	ISO 180
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	V-2		UL 94

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	520 to 560	°F
Front Temperature	540 to 580	°F
Nozzle Temperature	530 to 575	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	150 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

