

HiFill FR® PC 17R GAMMA FR GY386

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Additive	<ul style="list-style-type: none"> Flame Retardant
Features	<ul style="list-style-type: none"> Flame Retardant
Appearance	<ul style="list-style-type: none"> Grey
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	120		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	17	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3.50E+6	psi	ASTM D638
Tensile Strength (Yield)	9500	psi	ASTM D638
Tensile Elongation (Break)	7.0	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	280	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	270	°F	ASTM D648
CLTE - Flow	3.9	in/in/°F	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-2		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	520 to 560	°F
Middle Temperature	520 to 560	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	520 to 560	°F
Processing (Melt) Temp	530 to 575	°F
Mold Temperature	100 to 190	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 100	psi
Screw Speed	Slow-Moderate	

