

**HiFill FR® PC FR 06 NAT**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Features	• Flame Retardant
Appearance	• Colors Available      • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.21		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	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
<b>Mechanical</b>			
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Yield)	95	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	14	ft-lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	118		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	270	°F	ASTM D648
CLTE - Flow	3.8E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength	430	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating			UL 94
0.06 in		V-2	
0.12 in		V-0	

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	250	°F
Drying Time	4.0	hr
Rear Temperature	540 to 560	°F
Middle Temperature	540 to 560	°F
Front Temperature	540 to 560	°F
Processing (Melt) Temp	510 to 560	°F
Mold Temperature	180 to 250	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

