

HiFill FR® PC/ASA FR1520 UV GY336 A

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant • UV Stabilizer
Features	• Flame Retardant • UV Stabilized
Appearance	• Grey
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.22		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.010	in/in	ASTM D955
Mechanical			
Tensile Modulus	370000	psi	ASTM D638
Tensile Strength (Yield)	9500	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	> 25	%	ASTM D638
Impact			
Notched Izod Impact (0.125 in)	13	ft·lb/in	ASTM D256
Flammability			
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 530	°F
Middle Temperature	520 to 540	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	525 to 545	°F
Processing (Melt) Temp	520 to 545	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

