

HiFill FR® PC MCF/GB 1525 BK001

 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 ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.45		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-4	in/in	ASTM D955
Water Absorption (24 hr)	0.080	%	ASTM D570
Mechanical			
Tensile Modulus	1.03E+6	psi	ASTM D638
Tensile Strength (Yield)	16300	psi	ASTM D638
Tensile Elongation (Yield)	3.5	%	ASTM D638
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (73°F, 0.125 in)	11	ft·lb/in	ASTM D4812
Hardness			
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	305	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	300	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Electrical			
Surface Resistivity	1.0E+2 to 1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+2 to 1.0E+5	ohms·cm	ASTM D257
Flammability			
Flame Rating (0.06 in)	V-2		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

