

**HiFill® PC 121R Blue 304C**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Blue
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm <sup>3</sup>	
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	29	g/10 min	ASTM D1238
Moisture (284°F)	0.030	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8900	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	13	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
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	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
