

HiFill® PC 121R Gold 1245C

Techmer Polymer Modifiers - *Polycarbonate*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Gold
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ASTM D1238
Moisture (284°F)	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8800	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

¹ Typical properties: these are not to be construed as specifications.

