

HiFill® PC 121R Green 354C

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Green
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)	17	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8800	psi	ASTM D638
Tensile Strength (Break)	8800	psi	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
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.

