HiFill® PC GF10 LE

Techmer Polymer Modifiers - *Polycarbonate*

General Information

Product Description			
Polycarbonate 10% Glass Fibers, Low Extractable			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Features	• Creep Resistant • Fatigue Resistant	• Good Dimensional Stability • High Heat Resistance	• High Strength
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.28		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.13	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	650000	psi	ASTM D638
Tensile Strength (Break, 73°F)	12000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	3.5	%	ASTM D638
Flexural Modulus (73°F)	600000	psi	ASTM D790
Flexural Strength (Break, 73°F)	18000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.250 in)	1.8	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (M-Scale)	75		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	300	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	285	°F	ASTM D648
RTI Elec			UL 746B
0.06 in	167	°F	
0.12 in	167	°F	
RTI Imp			UL 746B
0.06 in	167	°F	
0.12 in	167	°F	
RTI Str			UL 746B
0.06 in	167	°F	
0.12 in	167	°F	
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.06 in	V-2		
0.12 in	V-0		

Processing Information

Injection	**Nominal Value**	**Unit**

Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	570 to 600	°F
Middle Temperature	590 to 650	°F
Front Temperature	600 to 630	°F
Nozzle Temperature	590 to 630	°F
Processing (Melt) Temp	580 to 625	°F
Mold Temperature	160 to 190	°F

Notes

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