HiFill® PC 17R LE GY256

Techmer Polymer Modifiers - *Polycarbonate*

General Information

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

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.50 to 0.70	in/in	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	9400	psi	ASTM D638
Tensile Elongation (Break)	80	%	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)	1.9	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	250	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Rear Temperature	520 to 550	°F
Middle Temperature	530 to 560	°F
Front Temperature	540 to 570	°F
Nozzle Temperature	580 to 590	°F
Processing (Melt) Temp	550 to 600	°F
Mold Temperature	180 to 250	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	

Notes

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