

**HiFill® SC030006 NAT**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Natural Color</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	320000	psi	ASTM D638
Tensile Strength (Yield)	9800	psi	ASTM D638
Tensile Strength (Break)	8900	psi	ASTM D638
Tensile Elongation (Break)	130	%	ASTM D638
Flexural Modulus	350000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	14	ft-lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	470 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	530 to 560	°F
Processing (Melt) Temp	530 to 560	°F
Mold Temperature	160 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

**Notes**

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

