

HiFill® PC121R Blue 306C

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
General

| | |
|-------------------|----------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Appearance | • Blue |
| 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) | 22 | g/10 min | ASTM D1238 |
| Moisture (284°F) | 0.050 | % | |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength (Yield) | 8700 | 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.
