

**HiFill® PC RX1851 Beige 7502C**

 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>Beige</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
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	9200	psi	ASTM D638
Tensile Strength (Break)	9000	psi	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.9	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	540 to 580	°F
Middle Temperature	550 to 590	°F
Front Temperature	560 to 600	°F
Nozzle Temperature	570 to 610	°F
Processing (Melt) Temp	550 to 605	°F
Mold Temperature	175 to 250	°F
Injection Rate	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.

