

**HiFill® PC GF/GM20 BK**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• Black
Processing Method	• Injection Molding

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

Physical	Nominal Value Unit	Test Method
Density / Specific Gravity	1.35	ASTM D792
Mechanical	Nominal Value Unit	Test Method
Tensile Modulus	600000 psi	ASTM D638
Tensile Strength (Yield)	11000 psi	ASTM D638
Tensile Elongation (Break)	4.5 %	ASTM D638
Impact	Nominal Value Unit	Test Method
Notched Izod Impact (0.125 in)	1.3 ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value Unit
Drying Temperature	250 °F
Drying Time	2.0 to 4.0 hr
Rear Temperature	550 to 600 °F
Middle Temperature	560 to 600 °F
Front Temperature	570 to 600 °F
Nozzle Temperature	570 to 600 °F
Processing (Melt) Temp	550 to 625 °F
Mold Temperature	175 to 225 °F
Injection Rate	Slow-Moderate
Back Pressure	0.00 to 50.0 psi
Screw Speed	Moderate

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