

**HiFill® PC 2458 White PMS 11-0601**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• White
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm <sup>3</sup>	
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	26	g/10 min	ASTM D1238
Moisture (284°F)	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9000	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	12	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 6.0	hr
Rear Temperature	550 to 590	°F
Middle Temperature	560 to 600	°F
Front Temperature	570 to 610	°F
Nozzle Temperature	580 to 620	°F
Processing (Melt) Temp	560 to 615	°F
Mold Temperature	200 to 275	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

