

**HiFill® PC RX1851 Purple 254C**

 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>Purple</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 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9200	psi	ASTM D638
Tensile Strength (Break)	8600	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	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	482 to 518	°F
Middle Temperature	518 to 554	°F
Front Temperature	545 to 581	°F
Nozzle Temperature	518 to 581	°F
Processing (Melt) Temp	536 to 608	°F
Mold Temperature	158 to 230	°F
Injection Rate	Slow-Moderate	
Back Pressure	1450 to 2900	psi
Screw Speed	Moderate	

