

**HiFill® PC RX1851 Navy Blue 280C**

 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>Blue</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	1.19		ASTM D792
Moisture (284°F)	0.030	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9200	psi	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	510 to 550	°F
Middle Temperature	520 to 560	°F
Front Temperature	530 to 570	°F
Nozzle Temperature	540 to 580	°F
Processing (Melt) Temp	525 to 585	°F
Mold Temperature	125 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

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