

HiFill® PC 2458 PMS 1665C OR

Techmer Polymer Modifiers - *Polycarbonate*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	23	g/10 min	ASTM D1238
Moisture (284°F)	0.020	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9300	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	13	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	

Notes

¹ Typical properties: these are not to be construed as specifications.

