

HiFill FR® FR-110 PL

 Techmer Polymer Modifiers - *Polycarbonate + ABS*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Additive	<ul style="list-style-type: none"> Flame Retardant
Features	<ul style="list-style-type: none"> Flame Retardant
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (240°C/5.0 kg)	26	g/10 min	ASTM D1238
Moisture (248°F)	0.030	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8500	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	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	515 to 555	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	150 to 225	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

