

**HiFill® PC/ABS 1950 WT357**

 Techmer Polymer Modifiers - *Polycarbonate + ABS*
**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 / Specific Gravity     | 1.12          |          | ASTM D792   |
| Mechanical                     | Nominal Value | Unit     | Test Method |
| Tensile Modulus                | 344000        | psi      | ASTM D638   |
| Tensile Strength (Yield)       | 7900          | psi      | ASTM D638   |
| Tensile Strength (Break)       | 6000          | psi      | ASTM D638   |
| Tensile Elongation (Break)     | 40            | %        | ASTM D638   |
| Impact                         | Nominal Value | Unit     | Test Method |
| Notched Izod Impact (0.125 in) | 9.6           | 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       | 460 to 500    | °F   |
| Middle Temperature     | 470 to 510    | °F   |
| Front Temperature      | 480 to 520    | °F   |
| Nozzle Temperature     | 490 to 530    | °F   |
| Processing (Melt) Temp | 465 to 525    | °F   |
| Mold Temperature       | 125 to 175    | °F   |
| Injection Rate         | Slow          |      |
| Back Pressure          | 25.0 to 75.0  | psi  |
| Screw Speed            | Slow-Moderate |      |

