

**HiFill® PC/ABS 1110 NAT**

 Techmer Polymer Modifiers - *Polycarbonate + ABS*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage - Flow (0.125 in)	0.60	%	ISO 2577
Water Absorption (24 hr, 73°F)	0.70	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	320000	psi	ISO 527-1
Tensile Stress (Yield)	7800	psi	ISO 527-2
Tensile Strain (Break)	45	%	ISO 527-2
Flexural Modulus	340000	psi	ISO 178
Flexural Stress	12000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	20	ft-lb/in	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	250	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ISO 75-2/A

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	510 to 575	°F
Mold Temperature	150 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

