

HiFill FR® C6200 FR 1508 GY204

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

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|-------------------|--|
| 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 |
| Appearance | <ul style="list-style-type: none"> Grey |
| Processing Method | <ul style="list-style-type: none"> Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--------------------------------|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.20 | | ASTM D792 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 405000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 9100 | psi | ASTM D638 |
| Tensile Strength (Break) | 6600 | psi | ASTM D638 |
| Tensile Elongation (Break) | 34 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 4.6 | ft·lb/in | ASTM D256 |
| Flammability | Nominal Value | Unit | Test Method |
| Flame Rating (0.06 in) | V-0 | | UL 94 |

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 | |

