

**HiFill FR® PC/ABS FR NH**

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

PAM114434

**General**

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant      • Halogen Free
Appearance	• Colors Available
Processing Method	• Injection Molding

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.18		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	490000	psi	ASTM D638
Tensile Strength (Yield)	7600	psi	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Flexural Modulus	440000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	11	ft·lb/in	ASTM D256
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	> 1.0E+15	ohms	ASTM D257
Volume Resistivity	> 1.0E+15	ohms·cm	ASTM D257
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	V-0		UL 94

**Processing Information**

	<b>Nominal Value</b>	<b>Unit</b>
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	465 to 515	°F
Middle Temperature	475 to 525	°F
Front Temperature	485 to 535	°F
Nozzle Temperature	495 to 545	°F
Mold Temperature	50 to 225	°F
<b>Extrusion</b>	<b>Nominal Value</b>	<b>Unit</b>
Melt Temperature	485 to 535	°F

