

HiFill® 57-10977 NAT

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

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.965		ASTM D792
Water Absorption (24 hr)	0.70	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	7800	psi	ASTM D638
Tensile Elongation (Break)	4.4	%	ASTM D638
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	251	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	215	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	230	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	430 to 445	°F
Middle Temperature	435 to 455	°F
Front Temperature	485 to 505	°F
Nozzle Temperature	485 to 505	°F
Processing (Melt) Temp	430 to 520	°F
Mold Temperature	120 to 175	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

