

HiFill® PC/ABS T85 UV Slate

Techmer Polymer Modifiers - *Polycarbonate + ABS*

General Information

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Material Status	• Commercial: Active
Availability	• North America
Features	• UV Resistant
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	28	g/10 min	ASTM D1238
Moisture (284°F)	0.030	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7100	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	11	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	225	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	490 to 530	°F
Mold Temperature	150 to 200	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

