

**HiFill® PC/PET 2230 OR073**

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

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	13	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	303000	psi	ASTM D638
Tensile Strength (Yield)	8200	psi	ASTM D638
Tensile Elongation (Break)	110	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	14	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 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 565	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

