

## HiFill® PC/PET 2230 YL122

Techmer Polymer Modifiers - *Polycarbonate + PET*

### General Information

#### General

|                   |                      |
|-------------------|----------------------|
| Material Status   | • Commercial: Active |
| Availability      | • North America      |
| Appearance        | • Yellow             |
| Processing Method | • Injection Molding  |

### Properties <sup>1</sup>

| Physical                                 | Nominal Value | Unit     | Test Method |
|------------------------------------------|---------------|----------|-------------|
| Density / Specific Gravity               | 1.21          |          | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (250°C/5.0 kg) | 11            | g/10 min | ASTM D1238  |
| Mechanical                               | Nominal Value | Unit     | Test Method |
| Tensile Strength (Yield)                 | 8100          | psi      | ASTM D638   |
| Impact                                   | Nominal Value | Unit     | Test Method |
| Notched Izod Impact (0.125 in)           | 13            | ft·lb/in | ASTM D256   |

### Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 250           | °F   |
| Drying Time            | 2.0 to 3.0    | hr   |
| Rear Temperature       | 490 to 520    | °F   |
| Middle Temperature     | 500 to 530    | °F   |
| Front Temperature      | 510 to 540    | °F   |
| Nozzle Temperature     | 520 to 550    | °F   |
| Processing (Melt) Temp | 495 to 550    | °F   |
| Mold Temperature       | 125 to 200    | °F   |
| Injection Rate         | Slow-Moderate |      |
| Back Pressure          | 25.0 to 75.0  | psi  |
| Screw Speed            | Slow          |      |

