

**HiFill® PC / PET 2230 HF UV**

 Techmer Polymer Modifiers - *Polycarbonate + PET*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Black • Colors Available
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.21		ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
260°C/2.16 kg	8.0	g/10 min	
275°C/1.0 kg	13	g/10 min	
Molding Shrinkage - Flow (0.125 in)	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.17	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength	7000	psi	ASTM D638
Tensile Elongation (Break)	40	%	ASTM D638
Flexural Modulus	320000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	10	ft-lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	117		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	265	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	250	°F	ASTM D648
CLTE - Flow	3.5E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	7.0E+15	ohms·cm	ASTM D257
Dielectric Strength	600	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating (0.06 in)	HB		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	210	°F
Drying Time	4.0	hr
Rear Temperature	460 to 510	°F
Middle Temperature	460 to 510	°F
Front Temperature	460 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	130 to 200	°F
Back Pressure	25.0 to 60.0	psi
Screw Speed	30 to 60	rpm

