

HiFill® PC-PBT Lt Prpl 17012820

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

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	21	g/10 min	ASTM D1238
Moisture (284°F)	0.060	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7400	psi	ASTM D638

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	230	°F
Drying Time	4.0 to 6.0	hr
Rear Temperature	470 to 510	°F
Middle Temperature	480 to 520	°F
Front Temperature	490 to 530	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	500 to 530	°F
Mold Temperature	150 to 190	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Moderate	

