

HiFill® PC / PBT IM 5720 BK

 Techmer Polymer Modifiers - *Polycarbonate + PBT*
General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• High Impact Resistance
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.17		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Elongation (Yield)	160	%	ASTM D638
Flexural Modulus	290000	psi	ASTM D790
Flexural Strength	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	11	ft·lb/in	
73°F, 0.125 in	14	ft·lb/in	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	245	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
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

