

**HiFill® PC/PBT IM 6702**

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

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/1.05 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	0.018	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Yield)	7180	psi	ASTM D638
Tensile Elongation (Break)	57	%	ASTM D638
Flexural Modulus	260000	psi	ASTM D790
Flexural Strength	9100	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	6.0	ft-lb/in	
73°F, 0.125 in	7.7	ft-lb/in	
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	108		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	240	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	185	°F	ASTM D648
CLTE - Flow	5.0E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating (0.13 in)	V-0		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

