

**HiFill® PC/PBT IM 5240 BK106**

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

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.015	in/in	ASTM D955
<b>Mechanical</b>			
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	75	%	ASTM D638
<b>Impact</b>			
Notched Izod Impact (0.125 in)	15	ft·lb/in	ASTM D256

**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
Nozzle Temperature	460 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

