

HiFill® PC/PBT IM 6370 GF30 LE

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

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Impact Modifier
Features	• Impact Modified • Low Extractables
Appearance	• Colors Available
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.44		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical			
Tensile Strength (Break)	13400	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	790000	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Hardness			
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	400	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	300	°F	ASTM D648
CLTE - Flow	1.5E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Flammability			
Flame Rating (0.06 in)	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

