

**HiFill FR® PC/ASA FR1520 UV GY335 A**

 Techmer Polymer Modifiers - *Polycarbonate + ASA*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant      • UV Stabilizer
Features	• Flame Retardant      • UV Stabilized
Appearance	• Grey
Processing Method	• Injection Molding

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.010	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Strength (Break)	7000	psi	ASTM D638
Tensile Elongation (Break)	> 20	%	ASTM D638
Flexural Modulus	400000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	7.0	ft·lb/in	ASTM D256
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 550	°F
Middle Temperature	520 to 560	°F
Front Temperature	530 to 570	°F
Nozzle Temperature	535 to 575	°F
Processing (Melt) Temp	515 to 575	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

