

HiFill® PC/PBT IM 6702

Polycarbonate + PBT

Techmer Engineered Solutions

Message:

HiFill® PC/PBT IM 6702 is a Polycarbonate + PBT (PC+PBT) product. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Impact Modified

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
Appearance	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/1.05 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	1.8	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	43.4	MPa	ASTM D638
Tensile Elongation (Break)	80	%	ASTM D638
Flexural Modulus	1790	MPa	ASTM D790
Flexural Strength	62.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	320	J/m	
23°C, 3.18 mm	320	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	116	°C	
1.8 MPa, Unannealed	85.0	°C	
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.18 mm)	V-0		UL 94

Injection	Nominal Value	Unit
Drying Temperature	98.9	°C
Drying Time	4.0	hr
Rear Temperature	238 to 266	°C
Middle Temperature	238 to 266	°C
Front Temperature	238 to 266	°C
Processing (Melt) Temp	238 to 266	°C
Mold Temperature	54.4 to 93.3	°C
Back Pressure	0.172 to 0.414	MPa
Screw Speed	30 to 60	rpm
NOTE		

- Method A (Short-Time)

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