

HiFill FR® PC FR IM

Polycarbonate
Techmer Engineered Solutions

Message:

HiFill FR®PC FR IM is a polycarbonate (PC) product. It can be processed by injection molding and is available in North America.

Features include:

- flame retardant/rated flame
- Flame Retardant
- Impact modification
- Impact resistance

General Information			
Additive	Impact modifier		
Features	Impact resistance, high		
	Flame retardancy		
Appearance	Available colors		
	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.13	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.2	MPa	ASTM D638
Tensile Elongation (Yield)	90	%	ASTM D638
Flexural Modulus	228	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	430	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	116	°C	ASTM D648
CLTE - Flow	6.7E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	17	kV/mm	ASTM D149

Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.0 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Rear Temperature	282 - 293	°C	
Middle Temperature	282 - 293	°C	
Front Temperature	282 - 293	°C	
Processing (Melt) Temp	266 - 293	°C	
Mold Temperature	82 - 121	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	30 - 60	rpm	
NOTE			

1. Method A (short time)

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