

HiFill® PC GF10 UV BK

Polycarbonate

Techmer Engineered Solutions

Message:

HiFill®PC GF10 UV BK is a polycarbonate (PC) product, which contains a 10% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

UV stability

| General Information | | | |
|-------------------------------------|---|-------------------|-------------|
| Filler / Reinforcement | Glass fiber reinforced material, 10% filler by weight | | |
| Additive | UV stabilizer | | |
| Appearance | Black | | |
| Forms | Particle | | |
| Processing Method | Injection molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.25 | g/cm ³ | ASTM D792 |
| Molding Shrinkage - Flow (3.18 mm) | 0.35 | % | ASTM D955 |
| Water Absorption (24 hr) | 0.12 | % | ASTM D570 |
| Hardness | Nominal Value | Unit | Test Method |
| Rockwell Hardness (R-Scale) | 124 | | ASTM D785 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength (Break) | 66.9 | MPa | ASTM D638 |
| Tensile Elongation (Break) | 8.0 | % | ASTM D638 |
| Flexural Modulus | 3450 | MPa | ASTM D790 |
| Flexural Strength | 110 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (23°C, 3.18 mm) | 110 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 0.45 MPa, not annealed | 146 | °C | ASTM D648 |
| 1.8 MPa, not annealed | 143 | °C | ASTM D648 |
| CLTE - Flow | 3.2E-5 | cm/cm/°C | ASTM D696 |
| Electrical | Nominal Value | Unit | Test Method |
| Volume Resistivity | 1.0E+17 | ohms · cm | ASTM D257 |
| Dielectric Strength ¹ | 18 | kV/mm | ASTM D149 |
| Flammability | Nominal Value | Unit | Test Method |
| Flame Rating (1.50 mm) | V-2 | | UL 94 |
| Injection | Nominal Value | Unit | |
| Drying Temperature | 121 | °C | |

| | | |
|------------------------|--------------|-----|
| Drying Time | 2.0 - 4.0 | hr |
| Suggested Max Moisture | 0.10 | % |
| Rear Temperature | 302 - 316 | °C |
| Middle Temperature | 316 - 332 | °C |
| Front Temperature | 310 - 327 | °C |
| Nozzle Temperature | 310 - 327 | °C |
| Processing (Melt) Temp | 304 - 327 | °C |
| Mold Temperature | 71.1 - 87.8 | °C |
| Injection Rate | Moderate | |
| Back Pressure | 0.00 - 0.689 | MPa |

Injection instructions

Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented mold Moisture Content, as received: Product is packaged at 0.2% or less.

NOTE

1. Method A (short time)

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