

HiFill® PC/PBT IM 5220 LE

Polycarbonate + PBT

Techmer Engineered Solutions

Message:

HiFill® PC/PBT IM 5220 LE is a polycarbonate polybutene terephthalate (PC PBT) product. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Impact modification

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Low extract		
Appearance	Available colors		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	52.4	MPa	ASTM D638
Tensile Elongation (Yield)	130	%	ASTM D638
Flexural Modulus	2000	MPa	ASTM D790
Flexural Strength	84.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	107	°C	ASTM D648
1.8 MPa, not annealed	98.9	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.57 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	98.9	°C	
Drying Time	4.0	hr	
Rear Temperature	238 - 266	°C	

Middle Temperature	238 - 266	°C
Front Temperature	238 - 266	°C
Processing (Melt) Temp	238 - 266	°C
Mold Temperature	54.4 - 93.3	°C
Back Pressure	0.172 - 0.414	MPa
Screw Speed	30 - 60	rpm

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Recommended distributors for this material

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