

HiFill® PC/PBT IM 6370 GF30

Polycarbonate + PBT

Techmer Engineered Solutions

Message:

HiFill® PC/PBT IM 6370 GF30 is a Polycarbonate + PBT (PC+PBT) product. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Appearance	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	92.4	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	5450	MPa	ASTM D790
Flexural Strength	138	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	190	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	204	°C	
1.8 MPa, Unannealed	149	°C	
CLTE - Flow	2.7E-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 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

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Recommended distributors for this material

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