

HiFill FR® PC NR 06 NAT

Polycarbonate
Techmer Engineered Solutions

Message:

HiFill FR® PC NR 06 NAT is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated
Flame Retardant

General Information			
Features	Flame Retardant		
Appearance	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Yield)	95	%	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	750	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	132	°C	ASTM D648
CLTE - Flow	6.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+17	ohms · cm	ASTM D257
Dielectric Strength	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	V-2		

3.00 mm	V-0	
Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	4.0	hr
Rear Temperature	282 to 293	°C
Middle Temperature	282 to 293	°C
Front Temperature	282 to 293	°C
Processing (Melt) Temp	266 to 293	°C
Mold Temperature	82.2 to 121	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 60	rpm

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