

HiFill® PC 0272 S1

Polycarbonate

Techmer Engineered Solutions

Message:

HiFill® PC 0272 S1 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. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.71	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.40	%	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			ASTM D638
Yield	43.4	MPa	ASTM D638
Fracture	66.9	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	2.0	%	ASTM D638
Fracture	8.0	%	ASTM D638
Flexural Modulus	2900	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	138	°C	ASTM D648
1.8 MPa, not annealed	132	°C	ASTM D648
CLTE - Flow	7.0E-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: MediumRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.		
NOTE		

1.
- Method A (short time)

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