

HiFill® PC / PET 2230

Polycarbonate + PBT
Techmer Engineered Solutions

Message:

HiFill® PC / PET 2230 is a Polycarbonate + PBT (PC+PBT) product. It can be processed by injection molding and is available in North America. Characteristics include:
Flame Rated
Impact Modified

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
Appearance	Black		
	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
265°C/2.16 kg	6.5	g/10 min	
300°C/1.2 kg	14	g/10 min	
Molding Shrinkage - Flow (3.18 mm)	0.80	%	ASTM D955
Water Absorption (24 hr)	0.17	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	48.3	MPa	ASTM D638
Tensile Elongation (Break)	70	%	ASTM D638
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	121	°C	ASTM D648
CLTE - Flow	6.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	7.0E+15	ohms · cm	ASTM D257
Dielectric Strength	24	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 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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