

# Edgetek™ PC-15GF/000 NC008

Polycarbonate

PolyOne Corporation

## Message:

Edgetek™PC-15GF/000 NC008 is a polycarbonate (PC) product containing a 15% glass fiber reinforced material. It can be processed by injection molding and is available in the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

| General Information                                                                        |                                                       |                   |                 |
|--------------------------------------------------------------------------------------------|-------------------------------------------------------|-------------------|-----------------|
| Filler / Reinforcement                                                                     | Glass fiber reinforced material, 15% filler by weight |                   |                 |
| Appearance                                                                                 | Black                                                 |                   |                 |
| Processing Method                                                                          | Injection molding                                     |                   |                 |
| Physical                                                                                   | Nominal Value                                         | Unit              | Test Method     |
| Specific Gravity                                                                           | 1.30                                                  | g/cm <sup>3</sup> | ASTM D792       |
| Molding Shrinkage - Flow                                                                   | 0.20 - 0.50                                           | %                 | ASTM D955       |
| Mechanical                                                                                 | Nominal Value                                         | Unit              | Test Method     |
| Tensile Strength <sup>1</sup>                                                              | 100                                                   | MPa               | ASTM D638       |
| Flexural Modulus <sup>2</sup>                                                              | 4500                                                  | MPa               | ASTM D790       |
| Flexural Strength <sup>3</sup>                                                             | 150                                                   | MPa               | ASTM D790       |
| Impact                                                                                     | Nominal Value                                         | Unit              | Test Method     |
| Notched Izod Impact (23°C, 3.20 mm)                                                        | 120                                                   | J/m               | ASTM D256       |
| Thermal                                                                                    | Nominal Value                                         | Unit              | Test Method     |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)                           | 135                                                   | °C                | ASTM D648       |
| Electrical                                                                                 | Nominal Value                                         | Unit              | Test Method     |
| Surface Resistivity                                                                        | 1.0E+15                                               | ohms              | ASTM D257       |
| Flammability                                                                               | Nominal Value                                         | Unit              | Test Method     |
| Flame Rating (3.20 mm)                                                                     | HB                                                    |                   | Internal method |
| Injection                                                                                  | Nominal Value                                         | Unit              |                 |
| Drying Temperature                                                                         | 110 - 130                                             | °C                |                 |
| Drying Time                                                                                | 3.0 - 4.0                                             | hr                |                 |
| Rear Temperature                                                                           | 280 - 310                                             | °C                |                 |
| Middle Temperature                                                                         | 280 - 310                                             | °C                |                 |
| Front Temperature                                                                          | 280 - 310                                             | °C                |                 |
| Mold Temperature                                                                           | 80.0 - 120                                            | °C                |                 |
| Injection instructions                                                                     |                                                       |                   |                 |
| Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW |                                                       |                   |                 |
| NOTE                                                                                       |                                                       |                   |                 |
| 1.                                                                                         | 5.0 mm/min                                            |                   |                 |
| 2.                                                                                         | 1.3 mm/min                                            |                   |                 |
| 3.                                                                                         | 1.3 mm/min                                            |                   |                 |

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