

# Edgetek™ CY1000 G20 BK001

Polycarbonate + ABS

PolyOne Corporation

Message:

Edgetek™CY1000 G20 BK001 is a polycarbonate + acrylonitrile butadiene styrene (PC + ABS) product, which contains a 20% glass fiber reinforced material. It can be processed by injection molding and is available in the Asia-Pacific region.

| General Information  |   |                   |             |
|--|---|-------------------|-------------|
| Filler / Reinforcement   | Glass fiber reinforced material, 20% filler by weight |                   |             |
| Appearance   | Black   |                   |             |
| Forms  | Particle  |                   |             |
| Processing Method  | Injection molding                                     |                   |             |
| Physical   | Nominal Value   | Unit              | Test Method |
| Specific Gravity   | 1.23  | 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>  | 90.0  | MPa               | ASTM D638   |
| Flexural Modulus <sup>2</sup>  | 7500  | MPa               | ASTM D790   |
| Flexural Strength <sup>3</sup>   | 130   | 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)                           | 120   | °C                | ASTM D648   |
| Electrical   | Nominal Value   | Unit              | Test Method |
| Surface Resistivity  | 1.0E+14   | ohms              | ASTM D257   |
| Injection  | Nominal Value   | Unit              |             |
| Drying Temperature   | 80.0 - 100  | °C                |             |
| Drying Time  | 3.0 - 4.0   | hr                |             |
| Rear Temperature   | 230 - 250   | °C                |             |
| Middle Temperature   | 230 - 250   | °C                |             |
| Front Temperature  | 230 - 250   | °C                |             |
| Mold Temperature   | 70.0 - 90.0   | °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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

