

# Edgetek™ PC-20GF/000 MR BLACK

Polycarbonate  
PolyOne Corporation

Message:  
20% glass fiber reinforced polycarbonate compound with outstanding mold releasing property

| General Information                                                                        |                                                       |                   |             |
|--------------------------------------------------------------------------------------------|-------------------------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                                                     | Glass fiber reinforced material, 20% filler by weight |                   |             |
| Appearance                                                                                 | Black                                                 |                   |             |
| Processing Method                                                                          | Injection molding                                     |                   |             |
| Physical                                                                                   | Nominal Value                                         | Unit              | Test Method |
| Specific Gravity                                                                           | 1.34                                                  | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage (3.00 mm)                                                                | 0.10 - 0.40                                           | %                 | ISO 294-4   |
| Mechanical                                                                                 | Nominal Value                                         | Unit              | Test Method |
| Tensile Strength <sup>1</sup>                                                              | 110                                                   | MPa               | ASTM D638   |
| Flexural Modulus <sup>2</sup>                                                              | 5800                                                  | 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)                           | 138                                                   | °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                                                                               |                                                       |                   | UL 94       |
| 1.50 mm                                                                                    | V-2                                                   |                   | UL 94       |
| 3.00 mm                                                                                    | V-0                                                   |                   | UL 94       |
| 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                                            |                   |             |

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