

# Edgetek™ PC-10CF/000 NH FR BK033

Polycarbonate

PolyOne Corporation

## Message:

Carbon Fiber Filled, Non-halogen Containing Flame Retardant Polycarbonate Compound

| General Information                                                                        |                                  |                   |                 |
|--------------------------------------------------------------------------------------------|----------------------------------|-------------------|-----------------|
| UL YellowCard                                                                              | E76261-102164665                 |                   |                 |
| Filler / Reinforcement                                                                     | Carbon fiber reinforced material |                   |                 |
| Features                                                                                   | Halogen-free                     |                   |                 |
|                                                                                            | Flame retardancy                 |                   |                 |
| Appearance                                                                                 | Black                            |                   |                 |
| Forms                                                                                      | Particle                         |                   |                 |
| Processing Method                                                                          | Injection molding                |                   |                 |
| Physical                                                                                   | Nominal Value                    | Unit              | Test Method     |
| Specific Gravity                                                                           | 1.24                             | g/cm <sup>3</sup> | ASTM D792       |
| Molding Shrinkage (3.00 mm)                                                                | 0.20 - 0.40                      | %                 | ISO 294-4       |
| Mechanical                                                                                 | Nominal Value                    | Unit              | Test Method     |
| Tensile Strength <sup>1</sup>                                                              | 100                              | MPa               | ASTM D638       |
| Tensile Elongation <sup>2</sup> (Break)                                                    | 3.0                              | %                 | ASTM D638       |
| Flexural Modulus <sup>3</sup>                                                              | 6500                             | MPa               | ASTM D790       |
| Flexural Strength <sup>4</sup>                                                             | 150                              | MPa               | ASTM D790       |
| Impact                                                                                     | Nominal Value                    | Unit              | Test Method     |
| Notched Izod Impact (23°C, 3.20 mm, Injection Molded)                                      | 70                               | J/m               | ASTM D256A      |
| Thermal                                                                                    | Nominal Value                    | Unit              | Test Method     |
| Deflection Temperature Under Load (1.8 MPa, Unannealed)                                    | 140                              | °C                | ASTM D648       |
| Electrical                                                                                 | Nominal Value                    | Unit              | Test Method     |
| Surface Resistivity                                                                        | 1.0E+2 - 1.0E+5                  | ohms              | ASTM D257       |
| Flammability                                                                               | Nominal Value                    | Unit              | Test Method     |
| Flame Rating (3.20 mm)                                                                     | V-0                              |                   | Internal method |
| Injection                                                                                  | Nominal Value                    | Unit              |                 |
| Drying Temperature                                                                         | 120 - 130                        | °C                |                 |
| Drying Time                                                                                | 4.0 - 6.0                        | hr                |                 |
| Processing (Melt) Temp                                                                     | 260 - 280                        | °C                |                 |
| Mold Temperature                                                                           | 90.0 - 110                       | °C                |                 |
| Injection instructions                                                                     |                                  |                   |                 |
| Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW |                                  |                   |                 |
| NOTE                                                                                       |                                  |                   |                 |

|    |            |
|----|------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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