

Edgetek™ Edgetek™ PC-20GF/000 FR BLK

Polycarbonate
PolyOne Corporation

Message:
20% glass fiber reinforced polycarbonate compound

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 ³	ASTM D792
Molding Shrinkage (3.00 mm)	0.25 - 0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	110	MPa	ASTM D638
Flexural Modulus ²	6000	MPa	ASTM D790
Flexural Strength ³	150	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	140	°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 (3.2 mm)	V-0		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 - 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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Recommended distributors for this material

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