



## Edgetek™ AT-15GB/000 BLACK

Acetal (POM) Copolymer

### Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Bead, 15% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.50	1.50	ASTM D792
Molding Shrinkage - Flow	0.015 to 0.019 in/in	1.5 to 1.9 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	6820 psi	47.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	363000 psi	2500 MPa	ASTM D790
Flexural Strength <sup>3</sup>	10900 psi	75.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	0.84 ft·lb/in	45 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	205 °F	96.0 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 194 °F	80.0 to 90.0 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Rear Temperature	374 to 392 °F	190 to 200 °C
Middle Temperature	374 to 392 °F	190 to 200 °C
Front Temperature	374 to 392 °F	190 to 200 °C
Mold Temperature	167 to 185 °F	75.0 to 85.0 °C

Injection Notes
Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

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**Notes**<sup>1</sup> Typical values are not to be construed as specifications.<sup>2</sup> 0.20 in/min (5.0 mm/min)<sup>3</sup> 0.051 in/min (1.3 mm/min)**CONTACT INFORMATION****Americas**United States - Avon Lake  
+1 440 930 1000United States - McHenry  
+1 815 385 8500**Asia**China - Guangzhou  
+86 20 8732 7260China - Shenzhen  
+86 755 2969 2888China - Suzhou  
+86 512 6823 24 38China - Suzhou  
+86 512 6265 2600Hong Kong -  
+852 2690 5332Taiwan - Yonghe City,  
+886 9396 99740, +886 2929 1849**Europe**Germany - Gaggenau  
+49 7225 6802 0Spain - Barbastro (Huesca)  
+34 974 310 314*Beyond Polymers.**Better Business Solutions.™*[www.polyone.com](http://www.polyone.com)**PolyOne Americas**33587 Walker Road  
Avon Lake, Ohio 44012  
United States  
+1 440 930 1000  
+1 866 POLYONE**PolyOne Asia**No. 88 Guoshoujing Road  
Z.J Hi-tech Park, Pudong  
Shanghai, 201203, China  
+86 21 5080 1188**PolyOne Europe**6 Giällewee  
+352 269 050 35

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