



Edgetek™ CY1000-20GF/000 BK005

Polycarbonate + ABS

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.28	1.28	ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 5.0E-3 in/in	0.20 to 0.50 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	13800 psi	95.0 MPa	ASTM D638
Flexural Modulus ³	1.09E+6 psi	7500 MPa	ASTM D790
Flexural Strength ³	22500 psi	155 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)	2.2 ft·lb/in	120 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)	248 °F	120 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+14 ohms	1.0E+14 ohms	ASTM D257

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 212 °F	80.0 to 100 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Rear Temperature	446 to 482 °F	230 to 250 °C
Middle Temperature	446 to 482 °F	230 to 250 °C
Front Temperature	446 to 482 °F	230 to 250 °C
Mold Temperature	158 to 194 °F	70.0 to 90.0 °C

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

Notes

¹ Typical values are not to be construed as specifications.

² 0.20 in/min (5.0 mm/min)

³ 0.051 in/min (1.3 mm/min)

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