



## Edgetek™ CY4000-65 NC015

### Polycarbonate + PBT

#### Key Characteristics

##### Product Description

Impact modified PC/PBT alloy

##### General

|                       |                      |
|-----------------------|----------------------|
| Material Status       | • Commercial: Active |
| Regional Availability | • Asia Pacific       |
| Features              | • Impact Modified    |
| Appearance            | • Natural Color      |
| Processing Method     | • Injection Molding  |

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

| Physical                               | Typical Value (English) | Typical Value (SI) | Test Method     |
|----------------------------------------|-------------------------|--------------------|-----------------|
| Density / Specific Gravity             | 1.21                    | 1.21               | ASTM D792       |
| Molding Shrinkage (0.118 in (3.00 mm)) | 0.40 to 0.70 %          | 0.40 to 0.70 %     | ISO 294-4       |
| Mechanical                             | Typical Value (English) | Typical Value (SI) | Test Method     |
| Tensile Strength <sup>2</sup>          | 8850 psi                | 61.0 MPa           | ASTM D638       |
| Flexural Modulus <sup>3</sup>          | 334000 psi              | 2300 MPa           | ASTM D790       |
| Flexural Strength <sup>3</sup>         | 13800 psi               | 95.0 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)        | 12 ft-lb/in             | 650 J/m            |                 |
| Thermal                                | Typical Value (English) | Typical Value (SI) | Test Method     |
| Deflection Temperature Under Load      |                         |                    | ASTM D648       |
| 264 psi (1.8 MPa), Unannealed          | 203 °F                  | 95.0 °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 (0.06 in (1.6 mm))        | HB                      | HB                 | Internal Method |

#### Processing Information

| Injection              | Typical Value (English) | Typical Value (SI) |
|------------------------|-------------------------|--------------------|
| Drying Temperature     | 176 to 212 °F           | 80 to 100 °C       |
| Drying Time            | 4.0 to 6.0 hr           | 4.0 to 6.0 hr      |
| Processing (Melt) Temp | 464 to 500 °F           | 240 to 260 °C      |
| Mold Temperature       | 158 to 194 °F           | 70 to 90 °C        |

##### Injection Notes

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

#### Notes

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 2.0 in/min (50 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)