



Edgetek™ Edgetek™ PC-20GF/000 FR BLK

Polycarbonate

Key Characteristics

Product Description	
20% glass fiber reinforced polycarbonate compound	
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
Density / Specific Gravity	1.34	1.34	ASTM D792
Molding Shrinkage (0.118 in (3.00 mm))	0.25 to 0.50 %	0.25 to 0.50 %	ISO 294-4
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	16000 psi	110 MPa	ASTM D638
Flexural Modulus ³	870000 psi	6000 MPa	ASTM D790
Flexural Strength ³	21800 psi	150 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.252 in (6.40 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)	284 °F	140 °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 (0.13 in (3.2 mm))	V-0	V-0	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	230 to 266 °F	110 to 130 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Rear Temperature	536 to 590 °F	280 to 310 °C
Middle Temperature	536 to 590 °F	280 to 310 °C
Front Temperature	536 to 590 °F	280 to 310 °C
Mold Temperature	176 to 248 °F	80 to 120 °C

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