Edgetek™ PC-20GF/000 FR BK
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
Specific Gravity	1.34	1.34	ASTM D792
Molding Shrinkage	0.20 to 0.50 %	0.20 to 0.50 %	ASTM D955
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	
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating			UL 94
0.0591 in (1.50 mm)	V-2	V-2	
0.118 in (3.00 mm)	V-0	V-0	
Glow Wire Flammability Index			Internal Method
0.0591 in (1.50 mm)	1560 °F	850 °C	
0.118 in (3.00 mm)	1650 °F	900 °C	
Glow Wire Ignition Temperature			Internal Method
0.0591 in (1.50 mm)	1470 °F	800 °C	
0.118 in (3.00 mm)	1560 °F	850 °C	

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	80.0 to 120 °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)

CONTACT INFORMATION

Americas

United States - Avon Lake
+1 440 930 1000

United States - McHenry
+1 815 385 8500

Asia

China - Guangzhou
+86 20 8732 7260

China - Shenzhen
+86 755 2969 2888

China - Suzhou
+86 512 6823 24 38

China - Suzhou
+86 512 6265 2600

Hong Kong -
+852 2690 5332

Taiwan - Yonghe City,
+886 9396 99740, +886 2929 1849

Europe

Germany - Gaggenau
+49 7225 6802 0

Spain - Barbastro (Huesca)
+34 974 310 314

Beyond Polymers.

Better Business Solutions. SM

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