



Edgetek™ PC-20GF/000 FR NATURAL

Polycarbonate

Key Characteristics

Product Description	
Non-halogen flame retardant	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant • Halogen Free
Appearance	• Natural Color
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.35	1.35	ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 4.0E-3 in/in	0.10 to 0.40 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	16000 psi	110 MPa	ASTM D638
Flexural Modulus ³	812000 psi	5600 MPa	ASTM D790
Flexural Strength ³	24700 psi	170 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)	2.4 ft-lb/in	130 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)	279 °F	137 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Volume Resistivity	1.0E+15 ohms·cm	1.0E+15 ohms·cm	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.0630 in (1.60 mm))	V-0	V-0	UL 94

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

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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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