



Edgetek™ CY4000 L BK025

Polycarbonate + PBT

Key Characteristics

Product Description

Impact modified PC/PBT alloy with outstanding impact strength and chemical resistance

General

Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Features	• Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
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 ²	8850 psi	61.0 MPa	ASTM D638
Flexural Modulus ³	334000 psi	2300 MPa	ASTM D790
Flexural Strength ³	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 (0.0630 in (1.60 mm))	HB	HB	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 212 °F	80.0 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	70.0 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 2.0 in/min (50 mm/min)

³ 0.051 in/min (1.3 mm/min)

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