



Edgetek™ PC-000/000 BK710

Polycarbonate

Key Characteristics

Product Description	
Un-Filled Polycarbonate Resin with Black Color	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20	ASTM D792
Molding Shrinkage (0.118 in (3.00 mm))	0.50 to 0.70 %	0.50 to 0.70 %	ISO 294-4
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	7980 psi	55.0 MPa	ASTM D638
Tensile Elongation ² (Break)	> 50 %	> 50 %	ASTM D638
Flexural Modulus ³	348000 psi	2400 MPa	ASTM D790
Flexural Strength ³	13100 psi	90.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact	9.4 ft-lb/in	500 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	257 °F	125 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	> 1.0E+12 ohms	> 1.0E+12 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	230 to 266 °F	110 to 130 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	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

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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