



Edgetek™ PC-10GF/000 FR V0 nat 70

Polycarbonate

Key Characteristics

Product Description	
Polycarbonate, 10% glass fiber reinforced, flame retardant V0, natural	
General	
Material Status	• Commercial: Active
Regional Availability	• Europe
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Features	• Flame Retardant
Appearance	• Natural Color
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.27	1.27	ISO 1183
Molding Shrinkage - Flow	3.0E-3 to 5.0E-3 in/in	0.30 to 0.50 %	ISO 294-4
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus	609000 psi	4200 MPa	ISO 527-2
Tensile Strength ²	9430 psi	65.0 MPa	ISO 527
Tensile Strain (Break)	5.0 %	5.0 %	ISO 527-2
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact Strength	5.9 ft-lb/in ²	13 kJ/m ²	ISO 180
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Heat Deflection Temperature 264 psi (1.8 MPa), Unannealed	288 °F	142 °C	ISO 75-2/A
Vicat Softening Temperature	302 °F	150 °C	ISO 306
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating	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 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)