



Edgetek™ PC-15CF/05T MR BLACK

Polycarbonate

Key Characteristics

Product Description	
Carbon fiber reinforced & PTFE lubricated polycarbonate	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.29	1.29	ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 3.0E-3 in/in	0.10 to 0.30 %	Internal Method
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength	19600 psi	135 MPa	ASTM D638
Flexural Modulus	1.40E+6 psi	9650 MPa	ASTM D790
Flexural Strength	25400 psi	175 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact	1.3 ft·lb/in	70 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	266 °F	130 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+3 to 1.0E+6 ohms	1.0E+3 to 1.0E+6 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating			Internal Method
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	212 to 248 °F	100 to 120 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Processing (Melt) Temp	518 to 608 °F	270 to 320 °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.