



Edgetek™ PC-15GF/000 BK023

Polycarbonate

Key Characteristics

| General | |
|------------------------|-------------------------------------|
| Material Status | • Commercial: Active |
| Regional Availability | • Asia Pacific |
| Filler / Reinforcement | • Glass Fiber, 15% Filler by Weight |
| Appearance | • Black |
| Processing Method | • Injection Molding |

Technical Properties ¹

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|--|-------------------------|--------------------|-----------------|
| Density / Specific Gravity | 1.30 | 1.30 | ASTM D792 |
| Molding Shrinkage - Flow | 2.0E-3 to 5.0E-3 in/in | 0.20 to 0.50 % | ASTM D955 |
| Mechanical | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength ² | 14500 psi | 100 MPa | ASTM D638 |
| Flexural Modulus ³ | 653000 psi | 4500 MPa | ASTM D790 |
| Flexural Strength ³ | 21800 psi | 150 MPa | ASTM D790 |
| Impact | Typical Value (English) | Typical Value (SI) | Test Method |
| Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm) | 2.2 ft·lb/in | 120 J/m | ASTM D256 |
| Thermal | Typical Value (English) | Typical Value (SI) | Test Method |
| Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm) | 275 °F | 135 °C | ASTM D648 |
| 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 (0.13 in (3.2 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 | 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)

³ 0.051 in/min (1.3 mm/min)



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