



## Edgetek™ PC-15GF/000 NC008

### 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 <sup>1</sup>

| 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 <sup>2</sup>                                                          | 14500 psi               | 100 MPa            | ASTM D638       |
| Flexural Modulus <sup>3</sup>                                                          | 653000 psi              | 4500 MPa           | ASTM D790       |
| Flexural Strength <sup>3</sup>                                                         | 21800 psi               | 150 MPa            | ASTM D790       |
| Impact                                                                                 | Typical Value (English) | Typical Value (SI) | Test Method     |
| Notched Izod Impact<br>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<br>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**

<sup>1</sup> Typical values are not to be construed as specifications.

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<sup>2</sup> 0.20 in/min (5.0 mm/min)

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<sup>3</sup> 0.051 in/min (1.3 mm/min)



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