



Edgetek™ MP-10GF/000 BLACK

Polyphenylene Ether + PS

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.13	1.13	ASTM D792
Molding Shrinkage - Flow	3.0E-3 in/in	0.30 %	ASTM D955
Molding Shrinkage - Across Flow	5.0E-3 in/in	0.50 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus ²	600000 psi	4140 MPa	ASTM D638
Tensile Strength ²	12300 psi	85.0 MPa	ASTM D638
Tensile Elongation ² (Break)	5.0 %	5.0 %	ASTM D638
Flexural Modulus ³	580000 psi	4000 MPa	ASTM D790
Flexural Strength ³	23900 psi	165 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	2.1 ft·lb/in	110 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	262 °F	128 °C	
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			UL 94
0.0591 in (1.50 mm)	HB	HB	
0.118 in (3.00 mm)	HB	HB	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	194 to 212 °F	90.0 to 100 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Rear Temperature	518 to 572 °F	270 to 300 °C
Middle Temperature	518 to 572 °F	270 to 300 °C
Front Temperature	518 to 572 °F	270 to 300 °C
Mold Temperature	149 to 203 °F	65.0 to 95.0 °C

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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)

CONTACT INFORMATION

Americas

United States - Avon Lake
 +1 440 930 1000

United States - McHenry
 +1 815 385 8500

Asia

China - Guangzhou
 +86 20 8732 7260

China - Shenzhen
 +86 755 2969 2888

China - Suzhou
 +86 512 6823 24 38

China - Suzhou
 +86 512 6265 2600

Hong Kong -
 +852 2690 5332

Taiwan - Yonghe City,
 +886 9396 99740, +886 2929 1849

Europe

Germany - Gaggenau
 +49 7225 6802 0

Spain - Barbastro (Huesca)
 +34 974 310 314



Beyond Polymers.

Better Business Solutions.™

www.polyone.com

PolyOne Americas

33587 Walker Road
 Avon Lake, Ohio 44012
 United States
 +1 440 930 1000
 +1 866 POLYONE

PolyOne Asia

No. 88 Guoshoujing Road
 Z.J Hi-tech Park, Pudong
 Shanghai, 201203, China
 +86 21 5080 1188

PolyOne Europe

6 Giällewee
 +352 269 050 35

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