

Edgetek™ CY4000 BK006

Polycarbonate + PBT

PolyOne Corporation

Message:

Impact modified PC/PBT alloy with outstanding impact strength and chemical resistance

General Information			
Features	Impact modification		
	Good chemical resistance		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage (3.00 mm)	0.40 - 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	61.0	MPa	ASTM D638
Flexural Modulus ²	2300	MPa	ASTM D790
Flexural Strength ³	95.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	650	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	100	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 90.0	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	80.0 - 100	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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