

HOPELEX PCH-2006

Polycarbonate

Lotte Chemical Corporation

Message:

Easy mold release

Superior flame retardant

Available in transparent, translucent and opaque color

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Mold Release		
Uses	Electrical Housing		
Appearance	Clear/Transparent		
	Opaque		
	Translucent		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	63.7	MPa	ASTM D638
Tensile Elongation ² (Break)	80	%	ASTM D638
Flexural Modulus ³	2350	MPa	ASTM D790
Flexural Strength ⁴ (Yield)	88.3	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	98	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	120	°C	ASTM D648

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.00 mm	V-0	
3.00 mm	V-0	

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Suggested Max Regrind	20	%
Hopper Temperature	60.0 to 80.0	°C

Rear Temperature	290 to 310	°C
Middle Temperature	280 to 300	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	280 to 300	°C
Processing (Melt) Temp	290 to 310	°C
Mold Temperature	60.0 to 90.0	°C

NOTE

- | | |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 10 mm/min |
| 4. | 10 mm/min |

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