HOPELEX PC-1100

Polycarbonate

Lotte Chemical Corporation

Message:

Medium viscosity, high impact strength
High tensile strength, flexural strength, and elastic modulus

General Information			
Features	High Impact Resistance		
	High Stiffness		
	High Tensile Strength		
	Medium Viscosity		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (Yield)	61.8	MPa	ASTM D638
Tensile Elongation [2] (Break)	> 100	%	ASTM D638
Flexural Modulus [3]	2350	MPa	ASTM D790
Flexural Strength [4] (Yield)	90.2	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.18 mm)	780	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	143	°C	
1.8 MPa, Unannealed	132	°C	
Vicat Softening Temperature	150	°C	ASTM D1525 [5]
Optical	**Nominal Value**	**Unit**	**Test Method**
Refractive Index	1.585		ASTM D542
Transmittance	89.0	%	ASTM D1003
Haze	< 0.80	%	ASTM D1003
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
5.	Rate B (120°C/h), Loading 2 (50 N)

Recommended distributors for this material

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