

HOPELEX PCN-2004

Polycarbonate

Lotte Chemical Corporation

Message:

Easy mold release

Non-brominated, non-chlorinated flame retardant

Available in opaque color only

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Mold Release		
Uses	Electrical Housing		
Appearance	Opaque		
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)	58.8	MPa	ASTM D638
Tensile Elongation ² (Break)	> 100	%	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)	290	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	110	°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	100	°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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