

HOPELEX PCN-2002

Polycarbonate

Lotte Chemical Corporation

Message:

Easy mold release

Non-brominated, non-chlorinated flame retardant

Available in transparent, translucent and opaque color

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Mold Release		
Uses	Electrical Housing		
RoHS Compliance	RoHS Compliant		
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)	61.8	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)	740	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	132	°C	ASTM D648

Flammability	Nominal Value	Test Method
Flame Rating	UL 94	
1.50 mm	V-2	
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 Re grind	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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