

HOPELEX PCG-2205

Polycarbonate

Lotte Chemical Corporation

Message:

20% glass-fiber reinforced, easy mold release

Non-brominated, non-chlorinated flame retardant

Optimum combination of high modulus and impact strength

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Mold Release		
	High Impact Resistance		
	High Stiffness		
Uses	Electrical Housing		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.20 to 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	108	MPa	ASTM D638
Flexural Modulus ²	5200	MPa	ASTM D790
Flexural Strength ³ (Yield)	167	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	141	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
	V-0		
3.00 mm	5VA		
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	300 to 320	°C
Middle Temperature	290 to 310	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	290 to 310	°C
Processing (Melt) Temp	300 to 320	°C
Mold Temperature	80.0 to 110	°C
NOTE		
1.	50 mm/min	
2.	10 mm/min	
3.	10 mm/min	

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