

HOPELEX PC-1150UR

Polycarbonate
Lotte Chemical Corporation

Message:

UV stabilized and mold release agent included
Low viscosity, high tensile strength, flexural strength, and elastic modulus

General Information			
Additive	demoulding		
	UV stabilizer		
Features	Low viscosity		
	Rigidity, high		
	High tensile strength		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 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)	740	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	141	°C	ASTM D648
1.8 MPa, not annealed	130	°C	ASTM D648
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 Re grind	20	%
Hopper Temperature	60.0 - 80.0	°C
Rear Temperature	290 - 310	°C
Middle Temperature	280 - 300	°C
Front Temperature	270 - 290	°C
Nozzle Temperature	280 - 300	°C
Processing (Melt) Temp	290 - 310	°C
Mold Temperature	60.0 - 90.0	°C

NOTE

- | | |
|----|---------------------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 10 mm/min |
| 4. | 10 mm/min |
| 5. | 标准 B (120°C/h), 载荷2 (50N) |

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