

HOPELEX PCH-2002

Polycarbonate
Lotte Chemical Corporation

Message:
Easy mold release
Superior flame retardant
Available in transparent, translucent and opaque color

General Information	
Additive	Flame Retardant
Features	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)	63.7	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)	130	°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 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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