

HOPELEX PC-1220R

Polycarbonate
Lotte Chemical Corporation

Message:

Hopelex PC-1220R is low viscosity, high flowability, easy mold release polycarbonate, which is suitable for general injection applications. PC-1220R is especially designed for the purpose of easy mold release of small and complicated injection products.

General Information			
UL YellowCard	E85371-100144914		
Features	Good Mold Release		
	High Flow		
	Low Viscosity		
RoHS Compliance	RoHS Compliant		
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)	22	g/10 min	ASTM D1238
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)	90.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	139	°C	
1.8 MPa, Unannealed	128	°C	
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 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	
5.	Rate B (120°C/h), Loading 2 (50 N)	

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