

HOPELEX AF-3100

Polycarbonate + ABS

Lotte Chemical Corporation

Message:

10% glass-fiber reinforced PC/ABS, easy mold release

Non-brominated, non-chlorinated flame retardant

Optimum combination of high modulus and impact strength

General Information			
Additive	Flame Retardant		
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	1.20	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	88.3	MPa	ASTM D638
Tensile Elongation ² (Break)	> 6.0	%	ASTM D638
Flexural Modulus ³	3920	MPa	ASTM D790
Flexural Strength ⁴ (Yield)	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	115	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
3.00 mm	V-0		
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°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	280 to 300	°C
Middle Temperature	270 to 290	°C
Front Temperature	260 to 280	°C
Nozzle Temperature	270 to 290	°C
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	60.0 to 80.0	°C

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	

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