

HOPELEX TC-8001B

Polycarbonate

Lotte Chemical Corporation

Message:

Medium viscosity, easy mold release

Non-brominated, non-chlorinated flame retardant

Available in black color only

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Mold Release		
	Medium Viscosity		
	Thermally Conductive		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	3.0	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)	1.0 to 3.0	%	ASTM D638
Flexural Modulus ³	9810	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)	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	130	°C	ASTM D648
Thermal Conductivity ⁵	> 0.75	W/m/K	
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Max Regrind	10	%	
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.	Hot Wire Method	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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