

HOPELEX LX-7000

Polycarbonate

Lotte Chemical Corporation

Message:

High viscosity, high impact strength, easy mold release

General Information			
Features	Good Mold Release		
	High Impact Resistance		
	High Viscosity		
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)	8.5	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)	60.8	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			ASTM D648
0.45 MPa, Unannealed	140	°C	
1.8 MPa, Unannealed	130	°C	
Vicat Softening Temperature	150	°C	ASTM D1525 ⁵
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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