

HOPELEX PCN-2004G

Polycarbonate
Lotte Chemical Corporation

Message:
Medium viscosity, easy mold release
Available in black color only

General Information			
Features	Good Mold Release		
	Low Gloss		
	Medium Viscosity		
Appearance	Black		
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)	17	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	60.8	MPa	ASTM D638
Tensile Elongation ² (Break)	1.0 to 3.0	%	ASTM D638
Flexural Modulus ³	2940	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)	49	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
1.00 mm	V-0		
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	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	

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