

# HOPELEX PCP-2605

Polycarbonate  
Lotte Chemical Corporation

Message:

Easy mold release  
Non-brominated, non-chlorinated flame retardant  
Available in opaque color only

| General Information                                     |                    |                   |             |
|---------------------------------------------------------|--------------------|-------------------|-------------|
| Features                                                | Bromine Free       |                   |             |
|                                                         | Chlorine Free      |                   |             |
|                                                         | Flame Retardant    |                   |             |
|                                                         | Good Mold Release  |                   |             |
| Uses                                                    | Electrical Housing |                   |             |
| Appearance                                              | Opaque             |                   |             |
| Physical                                                | Nominal Value      | Unit              | Test Method |
| Specific Gravity                                        | 1.20               | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow                                | 0.50 to 0.70       | %                 | ASTM D955   |
| Mechanical                                              | Nominal Value      | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Yield)                   | 60.8               | MPa               | ASTM D638   |
| Tensile Elongation <sup>2</sup> (Break)                 | > 100              | %                 | ASTM D638   |
| Flexural Modulus <sup>3</sup>                           | 2350               | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup> (Yield)                  | 88.3               | MPa               | ASTM D790   |
| Impact                                                  | Nominal Value      | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                     | 590                | J/m               | ASTM D256   |
| Thermal                                                 | Nominal Value      | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 110                | °C                | ASTM D648   |
| Flammability                                            | Nominal Value      | Test Method       |             |
| Flame Rating                                            |                    |                   | UL 94       |
| 1.50 mm                                                 | V-1                |                   |             |
|                                                         | V-0                |                   |             |
| 3.00 mm                                                 | 5VB                |                   |             |
| 2.00 mm                                                 | 5VB                |                   |             |
| Injection                                               | Nominal Value      | Unit              |             |
| Drying Temperature                                      | 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       | 260 to 280   | °C |
| Middle Temperature     | 250 to 270   | °C |
| Front Temperature      | 240 to 260   | °C |
| Nozzle Temperature     | 260 to 270   | °C |
| Processing (Melt) Temp | 260 to 280   | °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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