LOTTE CHEMICAL

HOPELEX AG-3020

PC/ABS alloy resin

General information

● **Description**

PC/ABS with balanced flowability, impact properties and hydrolytic stability

● **Applications**

Wide variety of applications with electronic housings

Typical properties[1]

	Test method	Typical value	Unit
Physical			
Melt Flow Index, 250°C, 2.16 kg	ASTM D1238	-	g/10 min
Specific Gravity	ASTM D792	1.1	
Mold Shrinkage	ASTM D955	0.5~0.7	%
Mechanical			
Tensile Strength, yield, 50 mm/min	ASTM D638	580	kg_f/cm^2
Tensile Elongation, break, 50 mm/min	ASTM D638	> 80	%
Flexural Strength, yield, 10 mm/min	ASTM D790	880	kg_f/cm^2
Flexural Modulus, 10 mm/min	ASTM D790	24,000	kg_f/cm^2
IZOD Impact Strength, notched, 23°C, 1/8"	ASTM D256	55	$kg_f \cdot cm/cm$
notched, 23°C, 1/4"	ASTM D256	-	$kg_f \cdot cm/cm$
notched, -30°C, 1/8"	ASTM D256	10	$kg_f \cdot cm/cm$
Thermal			
Heat Distortion Temp. 4.6 kg_f/cm^2	ASTM D648	-	°C
18.6 kg_f/cm^2	ASTM D648	95	°C
Vicat Softening Temp. Rate B/50	ASTM D1525	-	°C

Notes

[1] Typical properties : these are not to be construed as specifications.

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Processing guides[1]

		Typical value	Unit
Drying condition			
Drying temperature		80 ~ 90	°C
Drying time		4	hr
Maximum moisture content		0.02	%
Injection molding			
Melt temperature		240 ~ 260	°C
Nozzle temperature		240 ~ 260	°C
Barrel	Rear zone	240 ~ 260	°C
	Middle zone	240 ~ 260	°C
	Front zone	230 ~ 250	°C
Hopper temperature		60 ~ 80	°C
Mold temperature		60 ~ 80	°C

Mold | Nozzle | Rear zone | Middle zone | Front zone | Hopper
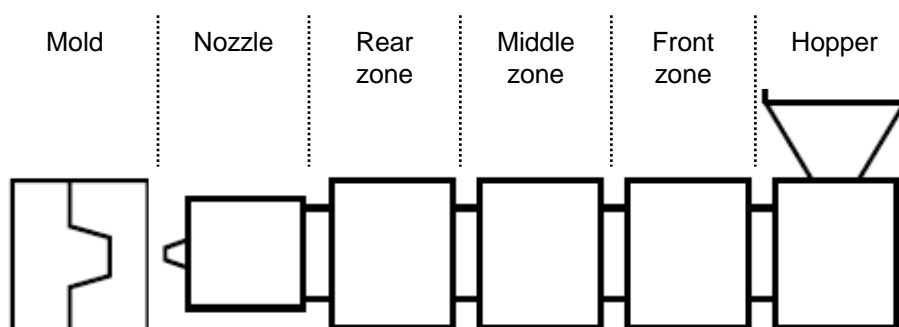
Recycling

Sprues and runners can be reground with virgin resin within the ratio of 20%. Care must be taken to ensure that the regrind is free from impurities and regrind should not be used in applications where impact performance and/or agency compliance are required.

Notes

ISO 9001, 14001, TS 16949

[1] Processing guides : Typical processing parameters are noted. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.