

HOPELEX PCH-2006

Polycarbonate compound resin

General information

Description

Easy mold release
 Superior flame retardant
 Available in transparent, translucent and opaque color

Applications

Multi purpose grade (electric/electronic housings, etc.)

Typical properties¹

	Test method	Typical value	Unit
Physical			
Melt Flow Index, 300°C, 1.2 kg	ASTM D1238	-	g/10 min
Specific Gravity	ASTM D792	1.2	
Mold Shrinkage	ASTM D955	0.5~0.7	%
Mechanical			
Tensile Strength, yield, 50 mm/min	ASTM D638	650	kg _f /cm ²
Tensile Elongation, break, 50 mm/min	ASTM D638	80	%
Flexural Strength, yield, 10 mm/min	ASTM D790	900	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	10	kg _f -cm/cm
	ASTM D256	-	kg _f -cm/cm
	ASTM D256	-	kg _f -cm/cm
Thermal			
Heat Distortion Temp.	4.6 kg _f /cm ²	ASTM D648	- °C
	18.6 kg _f /cm ²	ASTM D648	120 °C
Vicat Softening Temp.	Rate B/50	ASTM D1525	- °C
Flammability			
UL94 V-0	UL94	1.0	mm
UL94 V-0	UL94	3.0	mm

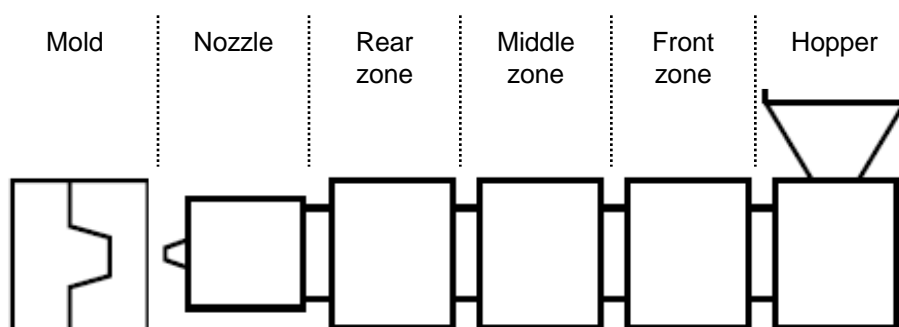
Notes

ISO 9001, 14001, TS 16949

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

Processing guides¹

	Typical value	Unit
Drying condition		
Drying temperature	120	°C
Drying time	4	hr
Maximum moisture content	0.02	%
Injection molding		
Melt temperature	290 ~ 310	°C
Nozzle temperature	280 ~ 300	°C
Barrel	Rear zone	290 ~ 310
	Middle zone	280 ~ 300
	Front zone	270 ~ 290
Hopper temperature	60 ~ 80	°C
Mold temperature	60 ~ 90	°C



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.