

AVP™ ZLL19CP

Polycarbonate
SABIC Innovative Plastics

Message:

AVP™ ZLL19CP is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E121562-100305667		
Features	General Purpose		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	19	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, 3.18 mm)	56.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.18 mm)	50	%	ASTM D638
Flexural Modulus ³ (3.18 mm)	2210	MPa	ASTM D790
Flexural Strength ⁴ (3.18 mm)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Reverse Notch Izod Impact (23°C, 3.18 mm)	2100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	127	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-2		
3.00 mm	V-1		
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0	hr	
Drying Time, Maximum	16	hr	
Rear Temperature	282 to 293	°C	
Middle Temperature	288 to 316	°C	
Front Temperature	288 to 316	°C	
Nozzle Temperature	288 to 316	°C	
Processing (Melt) Temp	299 to 327	°C	
Mold Temperature	82.2 to 116	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
NOTE		
1.	51 mm/min	
2.	51 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	

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