

AVP™ ZLL30CP

Polycarbonate
SABIC Innovative Plastics

Message:

AVP™ ZLL30CP is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America. Primary characteristic: high flow.

General Information			
Features	High Flow		
Appearance	Opaque		
Forms	Pellets		
Processing Method	Injection Molding		
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)	30	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)	61.4	MPa	ASTM D638
Tensile Elongation ² (Break, 3.18 mm)	150	%	ASTM D638
Flexural Modulus ³ (3.18 mm)	2410	MPa	ASTM D790
Flexural Strength ⁴ (3.18 mm)	96.5	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
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Drying Time, Maximum	16	hr	
Rear Temperature	243 to 260	°C	
Middle Temperature	249 to 260	°C	
Front Temperature	260 to 271	°C	
Nozzle Temperature	254 to 271	°C	
Processing (Melt) Temp	260 to 282	°C	
Mold Temperature	71.1 to 93.3	°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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