

AVP™ TLL80CP

Polycarbonate
SABIC Innovative Plastics

Message:

AVP™ TLL80CP is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America.
Characteristics include:
Flame Rated
High Flow

General Information			
UL YellowCard	E121562-100305663		
Features	High Flow		
UL File Number	E134027		
Appearance	Clear/Transparent		
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)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2340	MPa	ASTM D638
Tensile Strength ¹ (Yield, 3.18 mm)	58.6	MPa	ASTM D638
Tensile Elongation ² (Break, 3.18 mm)	75	%	ASTM D638
Flexural Modulus ³ (3.18 mm, 50.8 mm Span)	2410	MPa	ASTM D790
Flexural Strength ⁴ (3.18 mm, 50.8 mm Span)	93.1	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 (1.52 mm)	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Drying Time, Maximum	16	hr	
Rear Temperature	249 to 271	°C	
Middle Temperature	260 to 271	°C	

Front Temperature	271 to 288	°C
Nozzle Temperature	266 to 282	°C
Processing (Melt) Temp	271 to 288	°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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