AVP™ TLL06CU

Polycarbonate

SABIC Innovative Plastics

Message:

AVP[™] TLL06CU is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America. Characteristics include: Eco-Friendly/Green UV Stabilized

| AdditiveUV StabilizerRecycled ContentYesFeaturesGeneral Purpose Low FlowUsesGeneral PurposeAppearanceClear/TransparentFormsPelletsProcesing MethodInjection MoldingPhysicalNominal ValueUnitMeth Mass-Flow Rate (MFR) (300°C/12 kg)6.0g/Cm ³ Molding Shrinkage - Flow0.50 to 0.70%MechanicalNominal ValueUnitTestile Elongation ² (Break, 3.18 mm)10.0%Span)2.310MPaASTM D538Flewural Strength ⁴ (3.18 mm, 50.8 mm Span)2.310MPaSpan)89.6MPaASTM D790InspactNominal ValueUnitTest MethodNortical Strength ⁴ (3.18 mm, 50.8 mm Span)39.6MPaASTM D730Spani2.310MPaASTM D730InspactNominal ValueUnitTest MethodNotched Izod Impact (23°C, 3.18 mm)640J/mASTM D730InspactNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)127°CMorinal ValueUnitTest MethodDeflection Temperature121°CDrying Time, Maximum16hrProving Time, Maximum16hrRear Temperature299 to 321°C | General Information | | | |
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| Recycled ContentYesFeaturesGeneral Purpose Low FlowUsesGeneral PurposeAppearanceClear/TransparentFormsPeletsProcessing MethodInjection MoldingPhysicalNominal ValueUnitPhysical120g/cm ³ Mothing Shrinkage - Flow0.50 to 0.70% 100 minMethoding56 do 0.70% 100 minMethoding100 minal ValueUnitMethoding5.60 co.70% 100 minMethoding Shrinkage - Flow0.50 to 0.70% 100 minMethoding Shrinkage - Flow5.60 co.70% 100 minMethoding Shrinkage - Flow3.60 co.70% 100 minMethoding Shrinkage - Flow3.10 co.70% 100 minMethoding Shrinkage - Flow3 | | UV Stabilizer | | |
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| MechanicalNominal ValueUnitTest MethodTensile Strength ¹ (Yield, 3.18 mm)58.6MPaASTM D638Tensile Elongation ² (Break, 3.18 mm)110%ASTM D638Flexural Modulus ³ (3.18 mm, 50.8 mm Span)2310MPaASTM D790Flexural Strength ⁴ (3.18 mm, 50.8 mm Span)89.6MPaASTM D790ImpactNominal ValueUnitTest MethodNotched Izod Impact (23°C, 3.18 mm)640J/mASTM D256ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)127°CASTM D648InjectionNominal ValueUnitTest MethodDrying Temperature121°CCDrying Time, Maximum16hrCRear Temperature299 to 321°CC | Melt Mass-Flow Rate (MFR) (300°C/1.2 kg) | 6.0 | g/10 min | ASTM D1238 |
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| Drying Temperature121°CDrying Time4.0hrDrying Time, Maximum16hrRear Temperature299 to 321°C | | 127 | °C | ASTM D648 |
| Drying Time4.0hrDrying Time, Maximum16hrRear Temperature299 to 321°C | Injection | Nominal Value | Unit | |
| Drying Time, Maximum16hrRear Temperature299 to 321°C | Drying Temperature | 121 | °C | |
| Rear Temperature 299 to 321 °C | Drying Time | 4.0 | hr | |
| • | Drying Time, Maximum | 16 | hr | |
| Middle Temperature 310 to 332 °C | Rear Temperature | 299 to 321 | °C | |
| | Middle Temperature | 310 to 332 | °C | |
| Front Temperature 321 to 343 °C | Front Temperature | 321 to 343 | °C | |

| Nozzle Temperature | 316 to 338 | °C |
|------------------------|------------------------|-----|
| Processing (Melt) Temp | 321 to 343 | °C |
| Mold Temperature | 82.2 to 116 | °C |
| Back Pressure | 0.345 to 0.689 | MPa |
| Screw Speed | 40 to 70 | rpm |
| • | | • |
| NOTE | | · |
| · | 51 mm/min | |
| NOTE | 51 mm/min 51 mm/min | |
| NOTE 1. | | |

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