

AVP* GLG1P

Polycarbonate + Acrylic (PMMA)

SABIC Innovative Plastics

General		
Material Status	• Commercial: Active	
Availability	• North America	
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)	10 g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 to 0.80 %	ASTM D955
Mechanical	Nominal Value Unit	Test Method
Tensile Strength ² (Yield, 3.18 mm)	62.7 MPa	ASTM D638
Tensile Elongation ² (Break, 3.18 mm)	100 %	ASTM D638
Flexural Modulus ³ (3.18 mm)	2340 MPa	ASTM D790
Flexural Strength ³ (3.18 mm)	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
Injection	Nominal Value Unit	
Drying Temperature	121 °C	
Drying Time	4.0 hr	
Drying Time, Maximum	12 hr	
Suggested Shot Size	50 to 80 %	
Rear Temperature	249 to 277 °C	
Middle Temperature	249 to 277 °C	
Front Temperature	254 to 282 °C	
Nozzle Temperature	249 to 277 °C	
Processing (Melt) Temp	260 to 288 °C	
Mold Temperature	60.0 to 82.2 °C	
Back Pressure	0.172 to 0.345 MPa	
Screw Speed	30 to 70 rpm	

Notes

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

² 51 mm/min

³ 1.3 mm/min