

STAR PRIME™ RESINS

Grade: PCPBTQP7059

Molding Grade PCABS RoHS Compliant, All Colors, UV Available



TYPICAL MATERIAL PROPERTIES

| Physical | Nominal Values | ASTM Test |
|-----------------------------------|-------------------|-----------|
| Specific Gravity | 1.45 | D792 |
| Melt Flow (250°C/2.16 kg) | 8.5 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 506,000 psi | D638 |
| Tensile Strength @ Yield & Break | 15,100 psi | D638 |
| Flexural Modulus | 1,247,500 psi | D790 |
| Flexural Strength | 21,000 psi | D790 |
| % Elongation 0.2"/ min | 3700 | D638 |
| Impact | | |
| Notched Izod Impact (73°F, 0.125) | 1.8 ft-lb/in | D256 |
| Unnotched Izod | 13.1 ft-lb/in | D256 |
| Low Temp Impact Testing | 1.4 ft-lb/in | D256 |
| Thermal | | |
| HDT @ 66 PSI .250 "bar | 162°F | D648 |
| HDT @ 264 PSI .250 "bar | 131 | |
| Mold Shrinkage | | |
| Linear Flow | .004 - .007 in/in | D955 |
| Horizontal FR 0.060 " | 94 HB | D635 |

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, Inc/SDR Inc. assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. *No guarantees or warranties are expressed or implied.*

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RECOMMENDED PROCESSING GUIDELINES

| | Nominal Values |
|-------------------------------|------------------------------|
| Drying Time and Temperature | 3.0 - 4.0 hrs, 250°F - 280°F |
| Suggested Max Moisture | 0.020% |
| Rear Temperature | 450°F – 480°F |
| Middle Temperature | 460°F – 490°F |
| Front Temperature | 460°F – 490°F |
| Nozzle Temperature | 475°F – 500°F |
| Processing (Melt) Temperature | 475°F – 500°F |
| Mold Temperature | 150°F – 200°F |
| Back Pressure | 25 – 100 psi |
| Screw Speed | 25 – 75 RPM |

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

Rev0

Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds