ReStart™ Resins
Grade: PC7204(f1)
Molding Grade PCFR, with Elevated RTI’s and (f1)
Including 50% Certified Recycled Content Materials

**TYPICAL MATERIAL PROPERTIES**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>ASTM Test</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specific Gravity</td>
<td>1.20</td>
<td>D792</td>
</tr>
<tr>
<td>Melt Flow (300°C/1.2 kg)</td>
<td>15.0 g/10 min</td>
<td>D1238</td>
</tr>
</tbody>
</table>

**Mechanical**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>ASTM Test</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Modulus</td>
<td>350,000 psi</td>
<td>D638</td>
</tr>
<tr>
<td>Tensile Strength @ Yield</td>
<td>8,800 psi</td>
<td>D638</td>
</tr>
<tr>
<td>Flexural Modulus</td>
<td>350,000 psi</td>
<td>D790</td>
</tr>
<tr>
<td>Flexural Strength @ Yield</td>
<td>13,000 psi</td>
<td>D790</td>
</tr>
</tbody>
</table>

**Impact**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>ASTM Test</th>
</tr>
</thead>
<tbody>
<tr>
<td>Notched Izod Impact (73 °F, 0.125 in)</td>
<td>14.0 ft-lb/in</td>
<td>D256</td>
</tr>
</tbody>
</table>

**Thermal**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>ASTM Test</th>
</tr>
</thead>
<tbody>
<tr>
<td>DTUL @ 264 psi-unannealed (0.125 in)</td>
<td>260 °F</td>
<td>D648</td>
</tr>
</tbody>
</table>

**Mold Shrinkage**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>ASTM Test</th>
</tr>
</thead>
<tbody>
<tr>
<td>Linear Flow</td>
<td>.005 -.007 in/in</td>
<td>D955</td>
</tr>
<tr>
<td>UL Rating</td>
<td>(f1) UL746C</td>
<td></td>
</tr>
</tbody>
</table>

**Flammability**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>ASTM Test</th>
</tr>
</thead>
<tbody>
<tr>
<td>RTI</td>
<td>V-0 @ 3mm</td>
<td>UL 94</td>
</tr>
<tr>
<td>125°C, 115°C, 125°C</td>
<td>UL 746B</td>
<td></td>
</tr>
</tbody>
</table>

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.

*ReStart™ is a registered trademark of Star Plastics Inc; SDR Plastics Inc, its subsidiaries or affiliates.

**RECOMMENDED PROCESSING GUIDELINES**

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drying Time and Temperature</td>
<td>4.0 hrs at 250°F</td>
</tr>
<tr>
<td>Suggested Max Moisture</td>
<td>0.020%</td>
</tr>
<tr>
<td>Rear Temperature</td>
<td>520 – 550°F</td>
</tr>
<tr>
<td>Middle Temperature</td>
<td>530 – 570°F</td>
</tr>
<tr>
<td>Front Temperature</td>
<td>550 – 600°F</td>
</tr>
<tr>
<td>Nozzle Temperature</td>
<td>550 – 600°F</td>
</tr>
<tr>
<td>Processing (Melt) Temperature</td>
<td>550 – 600°F</td>
</tr>
<tr>
<td>Mold Temperature</td>
<td>170 – 220°F</td>
</tr>
<tr>
<td>Back Pressure</td>
<td>50 – 100 psi</td>
</tr>
<tr>
<td>Screw Speed</td>
<td>40 – 75 RPM</td>
</tr>
</tbody>
</table>

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