

STAR PRIME™ RESINS

Grade: PCHC7551 (f1)

Molding Grade: PCFR w/ UV, R, Cold Temp Impact Modified; In Black, Gray & Beige,
Non-Chlorinated & Non-Brominated



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.19	D792
Melt Flow (300°C/1.2 kg)	6.0 g/10 min	D1238
Mechanical		
Tensile Modulus	320,000 psi	D638
Tensile Strength @ Yield	8,400 psi	D638
Flexural Modulus	348,000 psi	D790
Flexural Strength @ Yield	9,000 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125)	17.0 ft-lb/in	D256
Notched Izod Impact (-40 °F, 0.125)	14.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	275 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .008 in/in	D955
UL Rating		
	(f1)	UL746C
Flammability	V-0 @ 1.5mm, 5VA @ 2.5mm	UL 94
RTI	125°C, 115°C, 125°C	UL746B
Non-Chlorinated & Non-Brominated		UL746H
Electrical		
Dielectric Constant 60Hz	2.95	ASTM D150
Dielectric Constant 1MHz	2.90	ASTM D150

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	4.0 hrs at 250°F
Suggested Max Moisture	0.020%
Rear Temperature	520 – 550°F
Middle Temperature	530 – 570°F
Front Temperature	550 – 600°F
Nozzle Temperature	550 – 600°F
Processing (Melt) Temperature	550 – 600°F
Mold Temperature	170 – 220°F
Back Pressure	50 – 100 psi
Screw Speed	40 – 75 RPM

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