

Grade: PC1107, R, UV, RUV

PC with UV and Release

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2kg)	28.0 g/10 min	D1238
Mechanical		
Tensile Modulus	280,000 psi	D638
Tensile Strength @ Yield	9,100 psi	D638
Tensile Strength @ Break	8,800 psi	D638
Flexural Modulus	330,000 psi	D790
Flexural Strength	13,000 psi	D790
Impact		
Notched Izod Impact (23°C, 0.125)	14.0 ft-lb/in	D256
Rockwell Hardness	120 R-Scale	D785
Thermal		
HDT (4.6kgf/cm ² , 6.4mm)	137°C	D648
VICAT(B/50)	290°F	ISO R 306
Mold Shrinkage		
MD,TD (Flow at 3.2mm)	0.5 - 0.7 %	D955
UL Rating	V2 (0.8-3.2mm)	UL 94

The information provided above is based upon typical values and is intended only as a guide. Star Plastics, LLC 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	475°F – 525°F
Middle Temperature	500°F – 550°F
Front Temperature	525°F – 575°F
Nozzle Temperature	525°F – 575°F
Processing (Melt) Temperature	525°F – 575°F
Mold Temperature	160°F – 210°F
Back Pressure	50 – 200 psi
Screw Speed	40 – 100 RPM

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