Grade: PC7502(f1)

Molding Grade PC FR w/ UV and Release, All Colors

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2kg)	20.0 g/10 min	D1238
Mechanical		
Tensile Modulus	345,000 psi	D638
Tensile Strength @ Yield	8,500 psi	D638
Flexural Modulus	345,000 psi	D790
Flexural Strength @ Yield	13,000 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	14.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	260 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .007 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

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	520°F – 550 °F
Middle Temperature	530°F – 570 °F
Front Temperature	550°F – 600 °F
Nozzle Temperature	550°F – 600 °F
Processing (Melt) Temperature	550°F – 600 °F
Mold Temperature	170°F – 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.