**Grade: re-PCABS-GP002**

Injection Molding Grade PC/ABS, GP

Including 50% Certified Recycled Content Materials

Certified to Federal Motor Vehicle Safety Standard No. 302 (FMCVSS 302).

**Typical Material Properties**

|  |  |  |  |
| --- | --- | --- | --- |
| **Physical** | **Nominal Values** | **ASTM Test** |  |
| Specific Gravity  Melt Flow (230°C/3.8 kg) | 1.13  20.0 g/10 min | D792  D1238 |  |
|  |  |  |  |
| **Mechanical** |  |  |  |
| Tensile Modulus  Tensile Strength @ Yield  Flexural Modulus  Flexural Strength @ Yield | 330,000 psi  8,000 psi  340,000 psi  12,000 psi | D638  D638  D790  D790 |  |
|  |  |  |  |
| **Impact** |  |  |  |
| Notched Izod Impact (73°F, 0.125 in) | 11.5 ft-lb/in | D256 |  |
|  |  |  |  |
| **Thermal** |  |  |  |
| DTUL @ 264 psi – Unannealed (0.125 in) | 225°F | D648 |  |
|  |  |  |  |
| **Mold Shrinkage** |  |  |  |
| Linear Flow | .004 – .007 in/in | D955 |  |

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.*

reNova™ is a registered trademark of Star Plastics, LLC, its subsidiaries or affiliates.

**Recommended Processing Guidelines**

|  |  |  |
| --- | --- | --- |
|  | **Nominal Values** |  |
| Drying Time and Temperature | 3.0 – 4.0 hrs at 190 – 230°F |  |
| Suggested Max Moisture | 0.020% |  |
| Rear Temperature | 460 – 540°F |  |
| Middle Temperature | 500 – 550°F |  |
| Front Temperature | 500 – 580°F |  |
| Nozzle Temperature | 500 – 580°F |  |
| Processing (Melt) Temperature | 500 – 580°F |  |
| Mold Temperature | 165 – 215°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.