

ValuPak Resins



Grade: PC4503,R,UV,RUV

Molding Grade, High Flow PC with Release, with UV, with Release and UV

326 Jack Burlingame Dr, Millwood, WV 25262 USA
Phone: 304.273.0352, Fax: 304.273.0355

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2 kg)	45.0 g/10 min	D1238
Mechanical		
Tensile Modulus	340,000 psi	D638
Tensile Strength @ Yield	8,200 psi	D638
Flexural Modulus	330,000 psi	D790
Flexural Strength @ Yield	11,500 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125)	5.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi un-annealed (0.125 in)	260°F	D648
Mold Shrinkage		
Linear Flow	.005 - .007 in/in	D955

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 (metric)
Drying Time and Temperature	4.0 hr, 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.

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