

STAR PRIME™ Resins



Grade: PBT820GF30
Molding Grade PBT w/ Glass

starplastics.com

Typical Material Properties

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Physical	Nominal Values	ASTM Test
Specific Gravity	1.53	D792
Melt Flow (250 °C/2.16 kg)	2.0 g/10 min	D1238
Mechanical		
Tensile Strength at Yield	16,600 psi	D638
Flexural Modulus	1,100,000 psi	D790
Flexural Strength at Yield	26,800 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	1.2 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	395 °F	D648
DTUL @ 66 psi-unannealed (.250 in)	420 °F	
Mold Shrinkage		
Linear Flow	.003 - .005 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
Drying Time and Temperature	4.0 hr, 240 – 250 °F
Suggested Max Moisture	0.020%
Rear Temperature	465 – 500 °F
Middle Temperature	475 – 510 °F
Front Temperature	475 – 520 °F
Nozzle Temperature	475 – 520 °F
Processing (melt) Temperature	485 – 525 °F
Mold Temperature	140 – 190 °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.

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