

STAR PRIME™ Resins



Grade: PBTGF15
Molding Grade 15% Glass Filled PBT

starplastics.com

Typical Material Properties

326 Jack Burlingame Dr, Millwood, WV 25262 USA
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| Physical | Nominal Values | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity | 1.40 | D792 |
| Mechanical | | |
| Tensile Strength at Yield | 11,000 psi | D638 |
| Flexural Modulus | 600,000 psi | D790 |
| Flexural Strength at Yield | 19,000 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 1.5 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.250 in) | 360 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .004 - .006 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, 230 – 250 °F |
| Suggested Max Moisture | 0.020% |
| Rear Temperature | 450 – 480 °F |
| Middle Temperature | 475 – 500 °F |
| Front Temperature | 475 – 510 °F |
| Nozzle Temperature | 475 – 510 °F |
| Processing (melt) Temperature | 485 – 525 °F |
| Mold Temperature | 120 – 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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