

# STAR PRIME™ Resins

Grade: PBTGF20  
Molding Grade 20% Glass Filled PBT



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## Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.45	D792
<b>Mechanical</b>		
Tensile Strength at Yield	17,000 psi	D638
Flexural Modulus	950,000 psi	D790
Flexural Strength at Yield	25,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	1.20 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.250 in)	375 °F	D648
<b>Mold Shrinkage</b>		
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	150 – 210 °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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