

STAR PRIME™ Resins



Grade: PC701, PC701R
Molding Grade PC, w/ Release

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Typical Material Properties

| Physical | Nominal Values | ASTM Test |
|---------------------------------------|---------------------------|-----------|
| Specific Gravity | 1.20 | D792 |
| Melt Flow (300 °C/1.2 kg) | 9.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 350,000 psi | D638 |
| Tensile Strength at Yield | 8,700 psi | D638 |
| Flexural Modulus | 345,000 psi | D790 |
| Flexural Strength at Yield | 13,000 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 15.0 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.125 in) | 265 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .005 - .007 in/in | D955 |
| UL Rating | HB (1.15 mm) ; V2(1.5 mm) | UL 94 |

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 hrs at 250 °F |
| Suggested Max Moisture | 0.020% |
| Rear Temperature | 520 - 560 °F |
| Middle Temperature | 530 - 570 °F |
| Front Temperature | 550 - 600 °F |
| Nozzle Temperature | 550 - 600 °F |
| Processing (melt) Temperature | 550 - 600 °F |
| Mold Temperature | 170 - 220 °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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