

# STAR PRIME™ Resins



Grade: PC721HF, PC721HFR  
Molding Grade High Flow 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)	25.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	345,000 psi	D638
Tensile Strength at Yield	8,700 psi	D638
Flexural Modulus	345,000 psi	D790
Flexural Strength at Yield	13,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	13.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	260 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.005 - .007 in/in	D955
<b>UL Rating</b>	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	475 - 525 °F
Middle Temperature	500 - 550 °F
Front Temperature	525 - 575 °F
Nozzle Temperature	525 - 575 °F
Processing (melt) Temperature	525 - 575 °F
Mold Temperature	160 - 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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