

# STAR PRIME™ Resins



Grade: PC741, PC741R  
Molding Grade PC, w/ Release

326 Jack Burlingame Dr, Millwood, WV 25262 USA  
Phone: 304.273.0352, Fax: 304.273.0355

## Typical Material Properties

| Physical                              | Nominal Values           | ASTM Test |
|---------------------------------------|--------------------------|-----------|
| Specific Gravity                      | 1.20                     | D792      |
| Melt Flow (300 °C/1.2 kg)             | 11.0 g/10 min            | D1238     |
| <b>Mechanical</b>                     |                          |           |
| Tensile Modulus                       | 350,000 psi              | D638      |
| Tensile Strength at Yield             | 9,000 psi                | D638      |
| Flexural Modulus                      | 350,000 psi              | D790      |
| Flexural Strength at Yield            | 13,000 psi               | D790      |
| <b>Impact</b>                         |                          |           |
| Notched Izod Impact (73 °F, 0.125 in) | 15 ft-lb/in              | D256      |
| <b>Thermal</b>                        |                          |           |
| DTUL @ 264 psi-unannealed (0.125 in)  | 265 °F                   | D648      |
| <b>Mold Shrinkage</b>                 |                          |           |
| Linear Flow                           | .005 - .007 in/in        | D955      |
| <b>UL Rating</b>                      | 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 - 550 °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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