

STAR PRIME™ Resins



Grade: PCABSFR9002

Molding Grade PCABSFR RoHS Compliant, Available in all colors, UV available

Typical Material Properties

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

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (260 °C/2.16 kg)	17.0 g/10 min	D1238
Mechanical		
Tensile Modulus	415,000 psi	D638
Tensile Strength at Yield	9,000 psi	D638
Flexural Modulus	380,000 psi	D790
Flexural Strength at Yield	14,000 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	10.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	191 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .007 in/in	D955
UL Rating		
	VO (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	3.0 - 4.0 hrs at 180 - 220 °F
Suggested Max Moisture	0.020%
Rear Temperature	450 - 500 °F
Middle Temperature	475 - 525 °F
Front Temperature	475 - 550 °F
Nozzle Temperature	475 - 550 °F
Processing (melt) Temperature	475 - 550 °F
Mold Temperature	135 - 185 °F
Back Pressure	25 - 100 psi
Screw Speed	25 - 75 rpm

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

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