

# STAR PRIME™ Resins



Grade: PC/ABSQX7004  
Molding Grade PC/ABS

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## Typical Material Properties

| Physical                              | Nominal Values    | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity                      | 1.13              | D792      |
| Melt Flow (260 °C/5.0 kg)             | 10.0 g/10 min     | D1238     |
| <b>Mechanical</b>                     |                   |           |
| Tensile Modulus                       | 330,000 psi       | D638      |
| Tensile Strength at Yield             | 8,000 psi         | D638      |
| Flexural Modulus                      | 340,000 psi       | D790      |
| Flexural Strength at Yield            | 12,000 psi        | D790      |
| <b>Impact</b>                         |                   |           |
| Notched Izod Impact (73 °F, 0.125 in) | 11.5 ft-lb/in     | D256      |
| <b>Thermal</b>                        |                   |           |
| DTUL @ 264 psi-unannealed (0.250 in)  | 225 °F            | D648      |
| <b>Mold Shrinkage</b>                 |                   |           |
| Linear Flow                           | .004 - .007 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   | 3.0 - 4.0 hrs at 190 - 230 °F |
| Suggested Max Moisture        | 0.020%                        |
| Rear Temperature              | 460 - 540 °F                  |
| Middle Temperature            | 500 - 550 °F                  |
| Front Temperature             | 500 - 580 °F                  |
| Nozzle Temperature            | 500 - 580 °F                  |
| Processing (melt) Temperature | 500 - 580 °F                  |
| Mold Temperature              | 165 - 215 °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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