

STAR PRIME™ Resins



Grade: PC/ABSQX7005
Molding Grade PC/ABS

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Typical Material Properties

| Physical | Nominal Values | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity | 1.10 | D792 |
| Melt Flow (260 °C/5.0 kg) | 15.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 310,000 psi | D638 |
| Tensile Strength at Yield | 7,000 psi | D638 |
| Flexural Modulus | 310,000 psi | D790 |
| Flexural Strength at Yield | 10,000 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 10.0 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.250 in) | 230 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .004 - .008 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 - 525 °F |
| Middle Temperature | 500 - 525 °F |
| Front Temperature | 500 - 550 °F |
| Nozzle Temperature | 500 - 550 °F |
| Processing (melt) Temperature | 500 - 550 °F |
| Mold Temperature | 150 - 200 °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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