

# STAR PRIME™ Resins



Grade: PC/ABSQX7012UV

Molding Grade PC/ABS Good Flow with Cold Temperature Impact and UV

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                      | 1.19              | D792      |
| Melt Flow (260 °C/5.0 kg)             | 10.0 g/10 min     | D1238     |
| <b>Mechanical</b>                     |                   |           |
| Tensile Modulus                       | 340,000 psi       | D638      |
| Tensile Strength at Yield             | 9,000 psi         | D638      |
| Flexural Modulus                      | 330,000 psi       | D790      |
| Flexural Strength at Yield            | 13,000 psi        | D790      |
| <b>Impact</b>                         |                   |           |
| Notched Izod Impact (73 °F, 0.125 in) | 11.0 ft-lb/in     | D256      |
| Notched Izod Impact (-30°C, 0.125 in) | 10.0 ft-lb/in     | D256      |
| <b>Thermal</b>                        |                   |           |
| DTUL @ 264 psi-unannealed (0.250 in)  | 230 °F            | D648      |
| <b>Mold Shrinkage</b>                 |                   |           |
| Linear Flow                           | .004 - .006 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.**

\*STARPRIME™ is a registered trademark of Star Plastics Inc; SDR Plastics Inc, its subsidiaries or affiliates.

## Recommended Processing Guidelines

|                               | Nominal Values             |
|-------------------------------|----------------------------|
| Drying Time and Temperature   | 3.0 – 4.0 hr, 180 – 230 °F |
| Suggested Max Moisture        | 0.020%                     |
| Rear Temperature              | 450 – 525 °F               |
| Middle Temperature            | 475 – 550 °F               |
| Front Temperature             | 475 – 550 °F               |
| Nozzle Temperature            | 475 – 550 °F               |
| Processing (melt) Temperature | 475 – 550 °F               |
| Mold Temperature              | 135 – 185 °F               |
| Back Pressure                 | 20 – 100 psi               |
| Screw Speed                   | 25 – 75 rpm                |

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

**Your Competitive Advantage in an Ever Changing Market!**