

STAR PRIME™ Resins



Grade: PC/ABSQX7020

Molding Grade PC/ABS Alloy designed for Plating Grade Applications

starplastics.com

Typical Material Properties

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Physical	Nominal Values	ASTM Test
Specific Gravity	1.10	D792
Melt Flow (260°C/5 kg.)	14.0 g/10 min	D1238
Mechanical		
Tensile Modulus	310,000 psi	D638
Tensile Strength at Yield	7,200 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 (0.125 in)	210 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .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 hr at 200 – 230 °F
Suggested Max Moisture	0.020%
Rear Temperature	460 – 525 °F
Middle Temperature	480 – 525 °F
Front Temperature	500 – 550 °F
Nozzle Temperature	500 – 550 °F
Processing (melt) Temperature	500 – 550 °F
Mold Temperature	160 – 210 °F
Back Pressure	50 – 100 psi
Screw Speed	30 – 75 rpm

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

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