

# STAR PRIME™ Resins



Grade: PC/PBTQX7008, PC/PBTQX7008UV  
Molding Grade PC/PBT, w/ UV

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## Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (230°C/3.8 kg.)	7.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	240,000 psi	D638
Tensile Strength at Yield	6,900 psi	D638
Flexural Modulus	255,000 psi	D790
Flexural Strength at Yield	12,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	12.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.250 in)	210 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.008 - .011 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	4.0 hrs at 250 °F
Suggested Max Moisture	0.020%
Rear Temperature	470 - 520 °F
Middle Temperature	480 - 530 °F
Front Temperature	495 - 540 °F
Nozzle Temperature	490 - 525 °F
Processing (melt) Temperature	500 - 535 °F
Mold Temperature	150 °F
Back Pressure	50 - 100 psi
Screw Speed	40 - 75 rpm

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

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