

STAR Prime™ Resins



Grade: PCQP310500R, UV, RUV

Molding Grade: FR Polycarbonate with 5% Glass with V0 and 5VA in black

starplastics.com

Typical Material Properties

326 Jack Burlingame Dr, Millwood, WV 25262 USA
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Physical	Nominal Values	ASTM Test
Specific Gravity	1.27	D792
Melt Flow (300 °C/1.2 kg)	12.0 g/10 min	D1238
Mechanical		
Tensile Modulus	375,000 psi	D638
Tensile Strength at Yield	8,400 psi	D638
Flexural Modulus	490,000 psi	D790
Flexural Strength at Yield	13,500 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	2.50 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	285 °F	D648
Mold Shrinkage		
Linear Flow	.003 - .005 in/in	D955
UL Rating		
Flammability	V-0 @ 1.5mm 5VA @ 2.5mm	UL 94

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	0.02%
Rear Temperature	520 - 550 °F
Middle Temperature	530 - 570 °F
Front Temperature	550 - 600 °F
Nozzle Temperature	550 - 600 °F
Processing (melt) Temperature	550 - 610 °F
Mold Temperature	150 - 220 °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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