

# VALUPAK™ Resins



Grade: PC1212FR, PC1212FRR, PC1212FRUV, PC1212FRRUV

Molding Grade PCFR, w/ Release, w/ UV, w/ UV and Release

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## Typical Material Properties

| Physical                              | Nominal Values         | ASTM Test |
|---------------------------------------|------------------------|-----------|
| Specific Gravity                      | 1.20                   | D792      |
| Melt Flow (300 °C/1.2 kg)             | 12 g/10 min            | D1238     |
| <b>Mechanical</b>                     |                        |           |
| Tensile Modulus                       | 345,000 psi            | D638      |
| Tensile Strength at Yield             | 8,500 psi              | D638      |
| Flexural Modulus                      | 345,000 psi            | D790      |
| Flexural Strength at Yield            | 12,500 psi             | D790      |
| <b>Impact</b>                         |                        |           |
| Notched Izod Impact (73 °F, 0.125 in) | 12 ft-lb/in            | D256      |
| <b>Thermal</b>                        |                        |           |
| DTUL @ 264 psi-unannealed (0.125 in)  | 260 °F                 | D648      |
| <b>Mold Shrinkage</b>                 |                        |           |
| Linear Flow                           | .005 - .007 in/in      | D955      |
| UL Rating (Pass)                      | HB (.045"); V2 (.062") | 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 hr at 250 °F |
| Suggested Max Moisture        | 0.020%           |
| Rear Temperature              | 520 - 550°F      |
| Middle Temperature            | 530 - 570°F      |
| Front Temperature             | 550 - 600 °F     |
| Nozzle Temperature            | 550 - 600 °F     |
| Processing (melt) Temperature | 550 - 600 °F     |
| Mold Temperature              | 170 - 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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