

# VALUPAK™ Resins



Grade: PC1510FRR, PC1510FRR, PC1510FRRUV, PC1510FRRUV  
Molding Grade PC, 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)	16 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)	270 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.005 - .007 in/in	D955
UL Rating	V2 (0.060")	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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