

# VALUPAK™ Resins



Grade: PC5GFMBFR, RUV, UV, R

Molding Grade PCFR w/ 5% Glass, Release, UV, Release and UV

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## Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.27	D792
Melt Flow (300 °C/1.2 kg)	12.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	350,000 psi	D638
Tensile Strength at Yield	7,500 psi	D638
Flexural Modulus	400,000 psi	D790
Flexural Strength at Yield	13,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	2.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	275 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.003 - .005 in/in	D955
<b>UL Rating</b>	VO (3.0 mm)	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, 250 °F
Suggested Max Moisture	0.020%
Rear Temperature	490 - 520 °F
Middle Temperature	510 - 560 °F
Front Temperature	560 - 590 °F
Nozzle Temperature	520 - 590 °F
Processing (melt) Temperature	500 - 575 °F
Mold Temperature	160 - 200 °F
Back Pressure	40 - 100 psi
Screw Speed	25 to 75 rpm

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

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