

VALUPAK™ Resins



Grade: PCGF20,PCGF20R,PCGF20UV,PCGF20RUV

Molding Grade PC 20% Glass, w/ Release, w/ UV, w/ UV and Release

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Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.34	D792
Melt Flow (300 °C/1.2 kg)	15 g/10 min	D1238
Mechanical		
Tensile Modulus	745,000 psi	D638
Tensile Strength at Yield	14,000 psi	D638
Flexural Modulus	750,000 psi	D790
Flexural Strength at Yield	17,500 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	1.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	285 °F	D648
Mold Shrinkage		
Linear Flow	.001 - .003 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	550 - 600 °F
Middle Temperature	575 - 625 °F
Front Temperature	600 - 650 °F
Nozzle Temperature	600 - 650 °F
Processing (melt) Temperature	600 - 650 °F
Mold Temperature	175 - 225 °F
Back Pressure	50 - 200 psi
Screw Speed	40 - 100 rpm

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

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