

STAR Prime™ Resins



Grade: PC8000

Low Melt Grade PCFR without Release or UV

starplastics.com

Typical Material Properties

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| Physical | Nominal Values | ASTM Test |
|---------------------------------------|--------------------|-----------|
| Specific Gravity | 1.20 | D792 |
| Melt Flow (300 °C/1.2 kg) | 4.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 350,000 psi | D638 |
| Tensile Strength at Yield | 9,000 psi | D638 |
| Flexural Modulus | 350,000 psi | D790 |
| Flexural Strength at Yield | 13,000 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 14.0 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.125 in) | 260 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .005 - .007 in/in | D955 |
| UL Rating | | |
| Flammability | V-0 @ 1.5 mm | UL 94 |
| RTI | 80 °C, 80°C, 80 °C | UL746B |

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 | 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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