STAR Prime™ Resins

Grade: PC8051
Molding Grade PCFR with 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)	25.0 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 @ 1.5mm	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 250º F
Suggested Max Moisture	0.020%
Rear Temperature	520 – 550 ºF
Middle Temperature	530 – 570 ºF
Front Temperature	550 – 600 ºF
NozzleTemperature	550 – 600 ºF
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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