

GRADE: RE-PCABS-GP002

Injection Molding Grade PC/ABS, GP

Including 50% Pre-consumer Validated Recycled Content Materials

Certified to Federal Motor Vehicle Safety Standard No. 302 (FMCVSS 302).

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.13	D792
Melt Flow (230°C/3.8 kg)	20.0 g/10 min	D1238
Mechanical		
Tensile Modulus	330,000 psi	D638
Tensile Strength @ Yield	8,000 psi	D638
Flexural Modulus	340,000 psi	D790
Flexural Strength @ Yield	12,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	11.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi – Unannealed (0.125 in)	225°F	D648
Mold Shrinkage		
Linear Flow	.004 – .007 in/in	D955

The information provided above is based upon typical values, and is intended only as a guide. Star Plastics, LLC 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	3.0 – 4.0 hrs at 190 – 230°F
Suggested Max Moisture	0.020%
Rear Temperature	460 – 540°F
Middle Temperature	500 – 550°F
Front Temperature	500 – 580°F
Nozzle Temperature	500 – 580°F
Processing (Melt) Temperature	500 – 580°F
Mold Temperature	165 – 215°F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM

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