

# STAR PRIME™ RESINS

Grade: PC/ABSQX7020

Molding Grade PC/ABS Alloy designed for Plating Grade Applications with Cold Temperature Impact Properties



## TYPICAL MATERIAL PROPERTIES

| Physical                              | Nominal Values    | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity                      | 1.14              | D792      |
| Melt Flow (260°C/5 kg)                | 14.0 g/10 min     | D1238     |
| <b>Mechanical</b>                     |                   |           |
| Tensile Modulus                       | 310,000 psi       | D638      |
| Tensile Strength @ Yield              | 8,000 psi         | D638      |
| Flexural Modulus                      | 340,000 psi       | D790      |
| Flexural Strength @ Yield             | 12,600 psi        | D790      |
| <b>Impact</b>                         |                   |           |
| Notched Izod Impact (73 °F, 0.125 in) | 12.0 ft-lb/in     | D256      |
| Notched Izod Impact (-22 °F, 0.125in) | 8.0 ft-lb/in      | D256      |
| <b>Thermal</b>                        |                   |           |
| DTUL @ 264 psi-unannealed (0.250 in)  | 230 °F            | D648      |
| <b>Mold Shrinkage</b>                 |                   |           |
| Linear Flow                           | .005 - .008 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   | 3.0 - 4.0 hrs at 200 - 230°F |
| Suggested Max Moisture        | 0.020%                       |
| Rear Temperature              | 460 – 525°F                  |
| Middle Temperature            | 480 – 525°F                  |
| Front Temperature             | 500 – 550°F                  |
| Nozzle Temperature            | 500 – 550°F                  |
| Processing (Melt) Temperature | 500 – 550°F                  |
| Mold Temperature              | 160 – 210°F                  |
| Back Pressure                 | 50 – 100 psi                 |
| Screw Speed                   | 30 – 75 RPM                  |

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

Rev0

Technical Data Sheet  
StarPlastics.com

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# Navigating Custom Compounds