

STAR PC GP18

General	
Availability	Global
Processing Method	Injection Molding General purpose
Description	PC

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.2 g/cm ³	ASTM D792
Melt Mass-Flow Rate	18 g/10 min	ASTM D1238

Mechanical		Nominal Value	Test Method
Tensile Stress	Yield	9000 psi	ASTM D638
	Break	10000 psi	
Tensile Elongation	Yield	6%	ASTM D638
	Break	120%	
	Flexural Modulus	335000 psi	ASTM D790
	Flexural Strength	13900 psi	ASTM D790

Impact	Nominal Value	Test Method
Notched Izod Impact	13 ft lb/in	ASTM D256

Thermal	Nominal Value	Test Method
HDT, 1.82 MPa, 3.2mm, Unannealed	132 C	ASTM D 648

Flammability		
Flame Rating (1.5mm)	V-2	UL 94

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.

Injection Processing	Nominal Value
Drying Temperature	120 C
Drying Time	3 to 4 hours
Suggested Max Moisture	0.02%
Rear Temperature	270 to 295 C
Middle Temperature	280 - 305 C
Front Temperature	295 - 315 C
Nozzle Temperature	290 - 315 C
Processing (melt) Temperature	295 - 315 C
Mold Temperature	70 - 95 C
Back Pressure	.3 - .07 MPa
Screw Speed	40 to 70 rpm
Vent Depth	.025 - .076 mm

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