

STAR PC GP7

General	
Availability	Global
Processing Method	Injection Molding
Description	General purpose PC

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.2 g/cm ³	ASTM D792
Melt Mass-Flow Rate	7 g/10 min	ASTM D1238

Mechanical		Nominal Value	Test Method
Tensile Modulus		2350 MPa	ASTM D638
Tensile Stress			ASTM D638
	Yield	63 MPa	
	Break	65 MPa	
Tensile Elongation			ASTM D638
	Yield	7%	
	Break	110%	
	Flexural Modulus	2300 MPa	ASTM D790
	Flexural Strength	93 MPa	ASTM D790

Impact	Nominal Value	Test Method
Notched Izod Impact	900 J/m	ASTM D256

Thermal	Nominal Value	Test Method
HDT, 1.82 MPa, 3.2mm, Unannealed	124 C	ASTM D648
CTE, -40C to 95C, flow	6.84E-05 1/C	ASTM E831

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.

Flammability		
Flame Rating (1.5mm)	HB	UL 94

Injection Processing	Nominal Value
Drying Temperature	120 C
Drying Time	3 to 4 hours
Suggested Max Moisture	0.02%
Rear Temperature	290 to 310 C
Middle Temperature	300 - 320 C
Front Temperature	310 - 330 C
Nozzle Temperature	305 - 330 C
Processing (melt) Temperature	310 - 330 C
Mold Temperature	80 - 115 C
Back Pressure	.3 - .07 MPa
Screw Speed	40 to 70 rpm
	.025 - .076
Vent Depth	mm

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