



## GRADE: RE-PCR-FR6501(F1)

Molding Grade PCFR, with Elevated RTIs and (f1), in Black, Gray & Beige Including 50% Pre-consumer Validated Recycled Content Materials

### Typical Material Properties

| Physical                               | Nominal Values                                  | ASTM Test        |
|--|---|------------------|
| Specific Gravity                       | 1.20  | D792             |
| Melt Flow (300°C/1.2 kg)               | 10 g/10 min                                     | D1238            |
| <b>Mechanical</b>                      |   |                  |
| Tensile Modulus                        | 345,000 psi                                     | D638             |
| Tensile Strength @ Yield               | 8,500 psi                                       | D638             |
| Flexural Modulus                       | 345,000 psi                                     | D790             |
| Flexural Strength @ Yield              | 13,000 psi                                      | D790             |
| <b>Impact</b>                          |   |                  |
| Notched Izod Impact (73°F, 0.125 in)   | 14.0 ft-lb/in                                   | D256             |
| <b>Thermal</b>                         |   |                  |
| DTUL @ 264 psi – Unannealed (0.125 in) | 260°F   | D648             |
| <b>Mold Shrinkage</b>                  |   |                  |
| Linear Flow                            | .005 – .007 in/in                               | D955             |
| <b>UL Rating</b>                       |   |                  |
| Flammability                           | (f1)  | <b>UL746C</b>    |
| RTI                                    | V-0 @ 1.5mm, 5VA @ 2.5mm<br>125°C, 115°C, 125°C | UL 94<br>UL 746B |

### Recommended Processing Guidelines

|                               | Nominal Values   |
|-------------------------------|------------------|
| Drying Time and Temperature   | 4.0 hrs at 250°F |
| Suggested Max Moisture        | 0.020%           |
| Rear Temperature              | 520 – 550°F      |
| Middle Temperature            | 530 – 570°F      |
| Front Temperature             | 550 – 600°F      |
| Nozzle Temperature            | 550 – 600°F      |
| Processing (Melt) Temperature | 550 – 600°F      |
| Mold Temperature              | 170 – 220°F      |
| Back Pressure                 | 50 – 100 psi     |
| Screw Speed                   | 40 – 75 RPM      |