

Orion™ RESINS

Grade: PBT820AFRGF30
FR Molding Grade PBT w/ Glass



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.58	D792
Melt Flow (250°C/2.16 kg)	2.0 g/10 min	D1238
Mechanical		
Tensile Strength @ Yield	16,500 psi	D638
Flexural Modulus	1,100,000 psi	D790
Flexural Strength @ Yield	26,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	1.2 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	395 °F	D648
DTUL @ 66 psi-unannealed (.250 in)	420 °F	
Mold Shrinkage		
Linear Flow	.003 - .005 in/in	D955
UL Rating		
	V0 (1.5 mm)	UL 94

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, LLC/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	4.0 hrs, 240 - 250°F
Suggested Max Moisture	0.020%
Rear Temperature	465 – 500°F
Middle Temperature	475 – 510°F
Front Temperature	475 – 520°F
Nozzle Temperature	475 – 520°F
Processing (Melt) Temperature	485 – 525°F
Mold Temperature	140 – 190°F
Back Pressure	50 – 100 psi
Screw Speed	40 – 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