

# Orion™ RESINS

Grade: PC1212FR, FRR, FRUV, FRRUV  
Molding Grade PCFR, w/ Release, w/ UV, w/ UV and Release



## TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2 kg)	12 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	12,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	12 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
UL Rating (Pass)	V2 (1.5mm)	UL 94

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.*

\*ValuPak™ is a registered trademark of Star Plastics Inc; SDR Plastics Inc, its subsidiaries or affiliates.

## 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

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

Rev0

Technical Data Sheet  
StarPlastics.com

Access: 12/6/17

# Navigating Custom Compounds