

Orion™ RESINS

Grade: PC721HF, PC721HFR

Molding Grade PC, w/ Release



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2kg)	25.0 g/10 min	D1238
Mechanical		
Tensile Modulus	345,000 psi	D638
Tensile Strength @ Yield	8,700 psi	D638
Flexural Modulus	345,000 psi	D790
Flexural Strength @ Yield	13,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	14.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	260 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .007 in/in	D955
UL Rating		
	V2 (3.0mm), V2 (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 at 250°F
Suggested Max Moisture	0.020%
Rear Temperature	475– 525°F
Middle Temperature	500 – 550°F
Front Temperature	525 – 575°F
Nozzle Temperature	525 – 575°F
Processing (Melt) Temperature	525 – 575°F
Mold Temperature	160 – 210°F
Back Pressure	50 – 200 psi
Screw Speed	40 – 100 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