

# Orion™ RESINS

Grade: PCGF10, PCGF10R, PCGF10UV, PCGF10RUV  
Molding Grade PC 10% Glass, w/ Release, w/ UV, w/ UV & Release



## TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.27	D792
Melt Flow (300°C/1.2 kg)	15 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	450,000 psi	D638
Tensile Strength @ Yield	9,500 psi	D638
Flexural Modulus	450,000 psi	D790
Flexural Strength @ Yield	14,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	1.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	275 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.003 - .005 in/in	D955

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.*

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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	550 – 600 °F
Middle Temperature	575 – 625 °F
Front Temperature	600 – 650 °F
Nozzle Temperature	600 – 650 °F
Processing (Melt) Temperature	600 – 650 °F
Mold Temperature	50 – 200 °F
Back Pressure	40 – 100 psi
Screw Speed	25 – 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