

GRADE: PC5GFMBFR, RUV, UV, R

Molding Grade PCFR w/ 5% Glass, Release, UV, Release & UV

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.27	D792
Melt Flow (300°C/1.2 kg)	12.0 g/10 min	D1238
Mechanical		
Tensile Modulus	350,000 psi	D638
Tensile Strength @ Yield	7,500 psi	D638
Flexural Modulus	400,000 psi	D790
Flexural Strength @ Yield	13,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	2.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	275°F	D648
Mold Shrinkage		
Linear Flow	.003 - .005 in/in	D955
UL Rating	V0 (3.0 mm and 6.0mm)	UL 94

The information provided above is based upon typical values, and is intended only as a guide. Star Plastics, LLC 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.*

Orion® is a registered trademark of Star Plastics, LLC, its subsidiaries or affiliates.

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	4.0 hrs, 250°F
Suggested Max Moisture	0.020%
Rear Temperature	490°F – 520°F
Middle Temperature	510°F – 560°F
Front Temperature	560°F – 590°F
Nozzle Temperature	520°F – 590°F
Processing (Melt) Temperature	500°F – 575°F
Mold Temperature	160°F – 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.