

Orion™ RESINS

Grade: PCQP310500

Molding Grade: FR Polycarbonate w/ 5% Glass, V0 & 5VA in Black, Release



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.27	D792
Melt Flow (300°C/1.2 kg)	6.0 g/10 min	D1238
Mechanical		
Tensile Modulus	375,000 psi	D638
Tensile Strength @ Yield	8,400 psi	D638
Flexural Modulus	490,000 psi	D790
Flexural Strength @ Yield	13,500 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	2.50 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	285 °F	D648
Mold Shrinkage		
Linear Flow	.003 - .005 in/in	D955
UL Rating		
Flammability	V-0 @ 1.5mm ; 5VA@ 2.5mm	UL94

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	520 – 550 °F
Middle Temperature	530 – 570 °F
Front Temperature	550 – 600 °F
Nozzle Temperature	550 – 600 °F
Processing (Melt) Temperature	550 – 610 °F
Mold Temperature	150 – 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

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Navigating Custom Compounds