Grade: PC7400(f2)

Molding Grade PC FR w/ UV and Release, All Colors but Clear

Typical Material Properties

Physical	Nominal Values	ASTM Test	
Specific Gravity	1.20	D792	
Melt Flow (300°C/1.2kg)	12.0 g/10 min	D1238	
Mechanical			
Tensile Modulus	345,000 psi	D638	
Tensile Strength @ Yield	8,500 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 - .008 in/in	D955	
UL Rating	(f2)	UL746C	
Flammability	V-0 @ 1.5mm, 5VA @ 3mm	UL 94	
RTI	125°C, 115°C, 125°C	UL746B	

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 at 250°F	
Suggested Max Moisture	0.020%	
Rear Temperature	520°F – 550 °F	
Middle Temperature	530°F – 570 °F	
Front Temperature	550°F – 600 °F	
Nozzle Temperature	550°F – 600 °F	
Processing (Melt) Temperature	550°F – 600 °F	
Mold Temperature	170°F – 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.