

## GRADE: PC1103FRRUV

Molding Grade PC w/ UV and Release

### Typical Material Properties

| Physical                             | Nominal Values    | ASTM Test |
|--------------------------------------|-------------------|-----------|
| Specific Gravity                     | 1.20              | D792      |
| Melt Flow (300°C/1.2kg)              | 11.5 g/10 min     | D1238     |
| <b>Mechanical</b>                    |                   |           |
| Tensile Modulus                      | 350,000 psi       | D638      |
| Tensile Strength @ Yield             | 9,000 psi         | D638      |
| Flexural Modulus                     | 350,000 psi       | D790      |
| Flexural Strength @ Yield            | 13,000 psi        | D790      |
| <b>Impact</b>                        |                   |           |
| Notched Izod Impact (73°F, 0.125 in) | 14.0 ft-lb/in     | D256      |
| <b>Thermal</b>                       |                   |           |
| DTUL @ 264 psi-unannealed (0.125 in) | 265 °F            | D648      |
| <b>Mold Shrinkage</b>                |                   |           |
| Linear Flow                          | .005 - .007 in/in | D955      |
| <b>UL Rating</b>                     | V2 (1.5mm)        | 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 at 250°F |
| Suggested Max Moisture        | 0.020%           |
| Rear Temperature              | 500°F – 530°F    |
| Middle Temperature            | 500°F – 530°F    |
| Front Temperature             | 500°F – 550°F    |
| Nozzle Temperature            | 500°F – 550°F    |
| Processing (Melt) Temperature | 500°F – 550°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.