

## GRADE: PC723, PC723R

Molding Grade PC, w/ UV, w/ UV and Release

### Typical Material Properties

| Physical                             | Nominal Values           | ASTM Test |
|--------------------------------------|--------------------------|-----------|
| Specific Gravity                     | 1.20                     | D792      |
| Melt Flow (300°C/1.2kg)              | 16.0 g/10 min            | D1238     |
| <b>Mechanical</b>                    |                          |           |
| Tensile Modulus                      | 345,000 psi              | D638      |
| Tensile Strength @ Yield             | 8,700 psi                | D638      |
| Flexural Modulus                     | 345,000 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) | 260 °F                   | D648      |
| <b>Mold Shrinkage</b>                |                          |           |
| Linear Flow                          | .005 - .007 in/in        | D955      |
| <b>UL Rating</b>                     | V2 (3.0 mm); V2 (1.5 mm) | UL 94     |

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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              | 475°F – 525°F    |
| Middle Temperature            | 500°F – 550°F    |
| Front Temperature             | 525°F – 575°F    |
| Nozzle Temperature            | 525°F – 575°F    |
| Processing (Melt) Temperature | 525°F – 575°F    |
| Mold Temperature              | 160°F – 210°F    |
| Back Pressure                 | 50 – 200 psi     |
| Screw Speed                   | 40 – 100 RPM     |

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.