

ORION® RESINS

Grade: PC/PBT7804

Molding Grade PC/PBT



Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (230°C/3.8 kg)	4.0 g/10 min	D1238
Mechanical		
Tensile Modulus	275,000 psi	D638
Tensile Strength @ Yield	7,000 psi	D638
Flexural Modulus	285,000 psi	D790
Flexural Strength @ Yield	10,500 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	12.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	215 °F	D648
Mold Shrinkage		
Linear Flow	.008 - .011 in/in	D955

The information provided above is based upon typical values, and are intended only as guides. 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.*

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Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	4.0 hrs at 240°F
Suggested Max Moisture	0.020%
Rear Temperature	460 – 480°F
Middle Temperature	475 – 510°F
Front Temperature	480 – 540°F
Nozzle Temperature	495 – 525°F
Processing (Melt) Temperature	495 – 535°F
Mold Temperature	120 – 170°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.

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Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds