



**GRADE: ORION® PCGF30, PCGF30R, PCGF30UV, PCGF30RUV**

Molding Grade PC with 30% Glass, with Release, with UV, with UV & Release

**Typical Material Properties**

Physical	Nominal Values	ASTM Test
Specific Gravity	1.34	D792
Melt Flow (300°C/1.2 kg)	15.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	745,000 psi	D638
Tensile Strength @ Yield	14,000 psi	D638
Flexural Modulus	750,000 psi	D790
Flexural Strength @ Yield	17,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	1.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi – Unannealed (0.125 in)	285°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.001 – .003 in/in	D955

**Recommended Processing Guidelines**

	Nominal Values
Drying Time and Temperature	4.0 hrs at 250°F
Suggested Max Moisture	0.020%
Rear Temperature	550 – 600°F
Middle Temperature	575 – 625°F
Front Temperature	600 – 650°F
Nozzle Temperature	600 – 650°F
Processing (Melt) Temperature	600 – 650°F
Mold Temperature	50 – 200°F
Back Pressure	40 – 100 psi
Screw Speed	25 – 75 RPM