

## ORION® RESINS

Grade: PC/PBT7820, PC/PBT7820UV

Molding Grade PC/PBT, w/ UV



### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (230°C/3.8 kg)	10 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	280,000 psi	D638
Tensile Strength @ Yield	7,500 psi	D638
Flexural Modulus	295,000 psi	D790
Flexural Strength @ Yield	12,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	12.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.250 in)	210 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.008 - .011 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	470 – 520°F
Middle Temperature	480 – 530°F
Front Temperature	495 – 540°F
Nozzle Temperature	490 – 525°F
Processing (Melt) Temperature	500 – 535°F
Mold Temperature	150°F
Back Pressure	50 – 100 psi
Screw Speed	40 – 75 RPM

# Navigating Custom Compounds