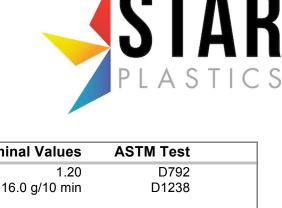
Orion™ RESINS

Grade: PCHC7301 (f1)

Molding Grade PCFR w/ UV and Release, All Colors but Clear

NCNB (Non-Chlorinated & Non-Brominated) FR PC

TYPICAL MATERIAL PROPERTIES



Physical	Nominal Values	ASTM Test	
Specific Gravity	1.20	D792	
Melt Flow (300°C/1.2 kg)	16.0 g/10 min	D1238	
Mechanical			
Tensile Modulus	350,000 psi	D638	
Tensile Strength @ Yield	8,800 psi	D638	
Flexural Modulus	350,000 psi	D790	
Flexural Strength @ Yield	13,000 psi	D790	
Impact			
Notched Izod Impact (73 °F, 0.125)	14.0 ft-lb/in	D256	
Thermal			
DTUL @ 264 psi-unannealed (0.125 in)	260 °F	D648	
Mold Shrinkage			
Linear Flow	.005007 in/in	D955	
UL Rating	(f1)	UL746C	
Flammability	V-0 @ 1.5mm	UL 94	
RTI	125°C, 115°C, 125°C	UL746B	
Non-Chlorinated & Non-Brominated		UL746H	

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, LLC/SDR Inc. 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.*

RECOMMENDED PROCESSING GUIDELINES

	Nominal Values	
Drying Time and Temperature	4.0 hrs at 250°F	
Suggested Max Moisture	0.020%	
Rear Temperature	520 – 550°F	
Middle Temperature	530 – 570°F	
Front Temperature	550 – 600°F	
Nozzle Temperature	550 – 600°F	
Processing (Melt) Temperature	550 – 600°F	
Mold Temperature	170 – 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.

Rev0 Technical Data Sheet Access: 11/7/18
StarPlastics.com

Navigating Custom Compounds

^{*}Orion™ is a registered trademark of Star Plastics LLC; SDR Plastics Inc, its subsidiaries or affiliates.