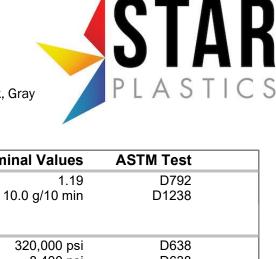
Orion™ resins

Grade: PCHC7552(f1)

Molding Grade: PCFR w/ UV, R, Cold Temp Impact Modified; In Black, Gray & Beige, Non- Chlorinated & Non-Brominated





Physical	Nominal Values	ASTM Test	
Specific Gravity	1.19	D792	
Melt Flow (300°C/1.2 kg)	10.0 g/10 min	D1238	
Mechanical			
Tensile Modulus	320,000 psi	D638	
Tensile Strength @ Yield	8,400 psi	D638	
Flexural Modulus	348,000 psi	D790	
Flexural Strength @ Yield	9,000 psi	D790	
Impact			
Notched Izod Impact (73 °F, 0.125)	17.0 ft-lb/in	D256	
Notched Izod Impact (-40 °F, 0.125)	14.0 ft-lb/in	D256	
Thermal			
DTUL @ 264 psi-unannealed (0.125 in)	275 °F	D648	
Mold Shrinkage			
Linear Flow	.004008 in/in	D955	
UL Rating	(f1)	UL746C	
Flammability	V-0 @ 1.5mm, 5VA @ 2.5mm	UL 94	
RTI	125°C, 115°C, 125°C	UL746B	
Non-Chlorinated & Non-Brominated	, , ,	UL746H	
Electrical			
Dielectric Constant 60Hz	2.95	ASTM D150	
Dielectric Constant 1MHz	2.90	ASTM D150	

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.

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

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.

StarPlastics.com Technical Data Sheet Access: 6/3/21 Rev0

Navigating Custom Compounds