

# Orion™ Resins

Grade: ABSFR1, ABSFR1UV  
Molding Grade ABSFR, w/ UV



## TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.22	D792
Melt Flow (230°C/3.8 kg)	7.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	315,000 psi	D638
Tensile Strength @ Yield	5,300 psi	D638
Flexural Modulus	325,000 psi	D790
Flexural Strength @ Yield	9,300 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	3.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	168 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.005 - .008 in/in	D955
UL Rating	V0 (1.5 mm); V-0,5VA (3.0mm)	UL 94

The information provided above is based upon typical values, and are intended only as guides. Star Plastics/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; SDR Plastics Inc, its subsidiaries or affiliates.

## RECOMMENDED PROCESSING GUIDELINES

	Nominal Values
Drying Time and Temperature	2.0 - 4.0 hrs at 170 - 190°F
Suggested Max Moisture	0.15%
Rear Temperature	300 – 360 °F
Middle Temperature	350 – 400 °F
Front Temperature	375 – 450 °F
Nozzle Temperature	375 – 450 °F
Processing (Melt) Temperature	375 – 450 °F
Mold Temperature	120 – 170 °F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

Rev0

Technical Data Sheet  
StarPlastics.com

Access: 12/6/17

# Navigating Custom Compounds