

GRADE: ORION® PC/ABSFR9001

Molding Grade PC/ABSFR RoHS Compliant, All Colors, UV available,
Non-Halogenated

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (260°C/2.16 kg)	11.0 g/10 min	D1238
Mechanical		
Tensile Modulus	400,000 psi	D638
Tensile Strength @ Yield	9,000 psi	D638
Flexural Modulus	388,000 psi	D790
Flexural Strength @ Yield	14,600 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	10.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi – Unannealed (0.125 in)	190°F	D648
Mold Shrinkage		
Linear Flow	.004 – .007 in/in	D955
UL Rating	V-0 @ 1.5 mm & 3.0 mm, 5VA @ 3.0 mm)	UL 94

The information provided above is based upon typical values, and is intended only as a guide. Star Plastics, LLC 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, its subsidiaries or affiliates.

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	3.0 – 4.0 hrs at 180 – 220°F
Suggested Max Moisture	0.020%
Rear Temperature	450 – 500°F
Middle Temperature	475 – 525°F
Front Temperature	475 – 550°F
Nozzle Temperature	475 – 550°F
Processing (Melt) Temperature	475 – 550°F
Mold Temperature	135 – 185°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.