

# ORION® RESINS

Grade: PCABSFR9502

Molding Grade PCABSFR RoHS Compliant, All Colors, UV available



## TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (260°C/2.16kg)	11.0 g/10 min	D1238
<b>Mechanical</b>		
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
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	10.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	190 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 - .007 in/in	D955
<b>UL Rating</b>		
	V0 @ 1.5 mm & 3.0mm, 5VA @ 3.0mm	UL 94

The information provided above is based upon typical values, and are intended only as guides. 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.*

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## 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.

Rev0

Technical Data Sheet  
StarPlastics.com

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# Navigating Custom Compounds