

ORION® RESINS

Grade: PCABSFR9503

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) | 13.0 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 | 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