GRADE: ORION® PCHC7550(F1)

Molding Grade PCFR w/ UV, R, Cold Temp Impact; All Colors,
Non-Chlorinated & Non-Brominated

Typical Material Properties

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 in)	17.0 ft-lb/in	D256	
Notched Izod Impact (-40°F, 0.125 in)	14.0 ft-lb/in	D256	
Thermal			
DTUL @ 264 psi – Unannealed (0.125 in)	275°F	D648	
Mold Shrinkage			
Linear Flow	.004 – .008 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 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	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.