

Grade: ABSFR1, UV

Molding Grade: ABSFR, w/ UV

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.22	D792
Melt Flow (230°C/3.8kg)	7.0 g/10 min	D1238
Mechanical		
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
Impact		
Notched Izod Impact (73 °F, 0.125 in)	3.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	168 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .008 in/in	D955
UL Rating		
Flammability	V-0 @ 1.5mm V-0 & 5VA @ 3.0mm	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.*

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Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2.0-4.0 hrs at 170°F-190°F
Suggested Max Moisture	0.15%
Rear Temperature	300°F – 360 °F
Middle Temperature	350°F – 400 °F
Front Temperature	375°F – 450 °F
Nozzle Temperature	375°F – 450 °F
Processing (Melt) Temperature	375°F – 450 °F
Mold Temperature	120°F – 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.