

## Grade: PC2000

PFAS Free, Halogen Compliant\* Molding Grade PCFR w/UV & Release, All colors

### Typical Material Properties

| Physical                              | Nominal Values           | ASTM Test |
|---------------------------------------|--------------------------|-----------|
| Specific Gravity                      | 1.20                     | D792      |
| Melt Flow (300°C/1.2 kg)              | 9.0 g/10 min             | D1238     |
| <b>Mechanical</b>                     |                          |           |
| Tensile Modulus                       | 350,000 psi              | D638      |
| Tensile Strength @ Yield              | 8,700 psi                | D638      |
| Flexural Modulus                      | 335,000 psi              | D790      |
| Flexural Strength @ Yield             | 13,000 psi               | D790      |
| <b>Impact</b>                         |                          |           |
| Notched Izod Impact (73 °F, 0.125 in) | 14.0 ft-lb/in            | D256      |
| <b>Thermal</b>                        |                          |           |
| DTUL @ 264 psi-unannealed (0.125 in)  | 265 °F                   | D648      |
| <b>Mold Shrinkage</b>                 |                          |           |
| Linear Flow                           | .005 - .007 in/in        | D955      |
| <b>UL Rating</b>                      |                          |           |
| Flammability                          | V-0 @ 1.5mm, V-0 @ 3.0mm | UL 94     |
| RTI                                   | 80°C, 80°C, 80°C         | UL746B    |

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

\*Halogen Compliant- per UL 746H & IEC61249-2-21 Contains <900ppm each of Bromine, Chlorine & <1500ppm total Halogen

\*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 – 610 °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.