

## Grade: Orion® 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

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### 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.