

# Orion™ Resins

Grade: PC/ABSQX7002

Molding Grade High Flow PC/ABS



## TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.15	D792
Melt Flow (260°C/5.0kg)	20.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	340,000 psi	D638
Tensile Strength @ Yield	9,000 psi	D638
Flexural Modulus	350,000 psi	D790
Flexural Strength @ Yield	14,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	11.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	235 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 - .006 in/in	D955

The information provided above is based upon typical values, and are intended only as guides. Star Plastics/SDR Inc. 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 - 230°F
Suggested Max Moisture	0.020%
Rear Temperature	450 – 525°F
Middle Temperature	475 – 550°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