

Orion™ Resins

Grade: PC/ABSQX7004

Molding Grade PC/ABS



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.13	D792
Melt Flow (260°C/5.0kg)	10.0 g/10 min	D1238
Mechanical		
Tensile Modulus	330,000 psi	D638
Tensile Strength @ Yield	8,000 psi	D638
Flexural Modulus	340,000 psi	D790
Flexural Strength @ Yield	12,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	11.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	225 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .007 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 190 - 230°F
Suggested Max Moisture	0.020%
Rear Temperature	460 – 540°F
Middle Temperature	500 – 550°F
Front Temperature	500 – 580°F
Nozzle Temperature	500 – 580°F
Processing (Melt) Temperature	500 – 580°F
Mold Temperature	165 – 215°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