

Orion™ Resins

Grade: PC/ABSQX7014

Molding Grade PC/ABS



TYPICAL MATERIAL PROPERTIES

| Physical | Nominal Values | ASTM Test |
|--------------------------------------|-------------------|-----------|
| Specific Gravity | 1.13 | D792 |
| Melt Flow (260°C/5.0kg) | 20.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 330,000 psi | D638 |
| Tensile Strength @ Yield | 8,100 psi | D638 |
| Flexural Modulus | 335,000 psi | D790 |
| Flexural Strength @ Yield | 12,500 psi | D790 |
| Impact | | |
| Notched Izod Impact (73°F, 0.125 in) | 6.0 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.125 in) | 230 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .004 - .006 in/in | D955 |
| Gloss (60°) | 50 | D523 |

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, 180 - 230°F |
| Suggested Max Moisture | 0.020% |
| Rear Temperature | 450 – 550°F |
| Middle Temperature | 475 – 550°F |
| Front Temperature | 475 – 575°F |
| Nozzle Temperature | 475 – 575°F |
| Processing (Melt) Temperature | 475 – 575°F |
| Mold Temperature | 135 – 185°F |
| Back Pressure | 30 – 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