

Orion™ Resins

Grade: PC/ABSQX7022

Molding Grade PC/ABS Alloy designed for Plating Grade Applications
w/ Cold Temperature Impact Properties



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.14	D792
Melt Flow (260°C/5 kg)	10.0 g/10 min	D1238
Mechanical		
Tensile Modulus	310,000 psi	D638
Tensile Strength @ Yield	8,000 psi	D638
Flexural Modulus	340,000 psi	D790
Flexural Strength @ Yield	12,600 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	12.0 ft-lb/in	D256
Notched Izod Impact (-22 °F, 0.125in)	8.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	230 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .008 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 200 - 230°F
Suggested Max Moisture	0.020%
Rear Temperature	460 – 525°F
Middle Temperature	480 – 525°F
Front Temperature	500 – 550°F
Nozzle Temperature	500 – 550°F
Processing (Melt) Temperature	500 – 550°F
Mold Temperature	160 – 210°F
Back Pressure	50 – 100 psi
Screw Speed	30 – 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

Access: 12/6/17

Navigating Custom Compounds