

Orion™ RESINS

Grade: PCPBTQP7059

Molding Grade PCABS RoHS Compliant, All Colors, UV Available



TYPICAL MATERIAL PROPERTIES

Physical	Nominal Values	ASTM Test
Specific Gravity	1.45	D792
Melt Flow (250°C/2.16 kg)	8.5 g/10 min	D1238
Mechanical		
Tensile Modulus	506,000 psi	D638
Tensile Strength @ Yield & Break	15,100 psi	D638
Flexural Modulus	1,247,500 psi	D790
Flexural Strength	21,000 psi	D790
% Elongation 0.2"/ min	3700	D638
Impact		
Notched Izod Impact (73°F, 0.125)	1.8 ft-lb/in	D256
Unnotched Izod	13.1 ft-lb/in	D256
Low Temp Impact Testing	1.4 ft-lb/in	D256
Thermal		
HDT @ 66 PSI .250 "bar	162°F	D648
HDT @ 264 PSI .250 "bar	131	
Mold Shrinkage		
Linear Flow	.004 - .007 in/in	D955
Horizontal FR 0.060 "	94 HB	D635

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, LLC/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, 250°F - 280°F
Suggested Max Moisture	0.020%
Rear Temperature	450°F – 480°F
Middle Temperature	460°F – 490°F
Front Temperature	460°F – 490°F
Nozzle Temperature	475°F – 500°F
Processing (Melt) Temperature	475°F – 500°F
Mold Temperature	150°F – 200°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