

Grade: Orion™ PC/ABSQX7004

Molding Grade PC/ABS

**Typical Material Properties**

|  |  |  |  |
| --- | --- | --- | --- |
| **Physical** | **Nominal Values** | **ASTM Test** | |
| Specific Gravity | 1.13 | D792 |  |
| Melt Flow (260°C/5.0 kg) | 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 |  |

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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.

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