

GRADE: ORION® PC/ABSQX7014

Molding Grade PC/ABS

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.13	D792
Melt Flow (260°C/5.0 kg)	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 is intended only as a guide. Star Plastics, LLC 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 180 - 230°F
Suggested Max Moisture	0.020%
Rear Temperature	450 – 525°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.