

ORION® RESINS

Grade: PC/PBTQX7026, PC/PBTQX7026UV
Molding Grade PC/PBT, w/ UV



Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.19	D792
Melt Flow (300°C/1.2 kg)	18.0 g/10 min	D1238
Mechanical		
Tensile Modulus	250,000 psi	D638
Tensile Strength @ Yield	7,100 psi	D638
Tensile Strength @ Break	6,000 psi	D638
Impact		
Notched Izod Impact (73°F, 0.125 in)	12.0 ft-lb/in	D256
Izod Impact, Notched Low Temp (-40°F @ 0.125 in)	10.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	205 °F	D648

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

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

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Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds