



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 |

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 |