



GRADE: ORION® PC/ABSQX7020

Molding Grade PC/ABS Alloy designed for Plating Grade Applications with Cold Temperature Impact Properties

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.14	D792
Melt Flow (260°C/5.0 kg)	14.0 g/10 min	D1238
Mechanical		
Tensile Modulus	310,000 psi	D638
Tensile Strength @ Yield	8,000 psi	D638
Flexural Modulus	340,000 psi	D790
Flexural Strength @ Yield	12,600 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	12.0 ft-lb/in	D256
Notched Izod Impact (-22°F, 0.125 in)	8.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi – Unannealed (0.250 in)	230°F	D648
Mold Shrinkage		
Linear Flow	.005 – .008 in/in	D955

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	460 – 525°F
Middle Temperature	480 – 525°F
Front Temperature	500 – 550°F
Nozzle Temperature	500 – 550°F
Processing (Melt) Temperature	500 – 550°F
Mold Temperature	160 – 210°F
Back Pressure	50 – 100 psi
Screw Speed	30 – 75 RPM