



ORION® RESINS

Grade: PC/PBTQX7008, PC/PBTQX7008UV
 Molding Grade PC/PBT, w/ UV

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (230°C/3.8 kg)	7.0 g/10 min	D1238
Mechanical		
Tensile Modulus	240,000 psi	D638
Tensile Strength @ Yield	6,900 psi	D638
Flexural Modulus	255,000 psi	D790
Flexural Strength @ Yield	12,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	12.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.250 in)	210 °F	D648
Mold Shrinkage		
Linear Flow	.008 - .011 in/in	D955

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	4.0 hrs at 250°F
Suggested Max Moisture	0.020%
Rear Temperature	470 – 520°F
Middle Temperature	480 – 530°F
Front Temperature	495 – 540°F
Nozzle Temperature	490 – 525°F
Processing (Melt) Temperature	500 – 535°F
Mold Temperature	150°F
Back Pressure	50 – 100 psi
Screw Speed	40 – 75 RPM

Navigating Custom Compounds