



GRADE: ORION® PCQP6005

Molding Grade PC, High Flow with Incremental Release

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2 kg)	28.0 g/10 min	D1238
Mechanical		
Tensile Modulus	345,000 psi	D638
Tensile Strength @ Yield	8,700 psi	D638
Flexural Modulus	345,000 psi	D790
Flexural Strength @ Yield	13,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	14.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi – Unannealed (0.125 in)	260 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .007 in/in	D955
UL Rating	V-2(1.5mm)	UL 94

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	4.0 hrs at 250°F
Suggested Max Moisture	0.020%
Rear Temperature	475 – 525°F
Middle Temperature	500 – 550°F
Front Temperature	525 – 575°F
Nozzle Temperature	525 – 575°F
Processing (Melt) Temperature	525 – 575°F
Mold Temperature	160 – 210°F
Back Pressure	50 – 200 psi
Screw Speed	40 – 100 RPM