

## GRADE: ORION® PCPBTQP7059

Molding Grade PCABS RoHS Compliant, All Colors, U Available

### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.45	D792
Melt Flow (250°C/2.16 kg)	8.5 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	506,000 psi	D638
Tensile Strength @ Yield	15,100 psi	D638
Flexural Modulus	1,247,500 psi	D790
Flexural Strength @ Yield	21,000 psi	D790
% Elongation 0.2"/min	3700	D638
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	1.8 ft-lb/in	D256
Unnotched Izod	13.1 ft-lb/in	D256
Low Temp Impact Testing	1.4 ft-lb/in	D256
<b>Thermal</b>		
HDT @ 66 PSI .250 "bar	161 °F	D648
HDT @ 264 PSI .250 "bar	131	
<b>Mold Shrinkage</b>		
Linear Flow	.004 - .007 in/in	D955
<b>Horizontal FR 0.060 "</b>		
	94 HB	D635

The information provided above is based upon typical values, and is intended only as a guide. 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, 250°F – 280°F
Suggested Max Moisture	0.020%
Rear Temperature	450°F – 480°F
Middle Temperature	460°F – 490°F
Front Temperature	460°F – 490°F
Nozzle Temperature	475°F – 500°F
Processing (Melt) Temperature	475°F – 500°F
Mold Temperature	150°F – 200°F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM

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