AuroraGuard™ 11HFIM

Aurora Material Solutions, LLC - *Acrylonitrile Butadiene Styrene*

General Information

Product Description			
High Flow, Impact Modified ABS Formerly known as EnCore 11HFIM			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• High Flow	• Impact Modified	
Uses	• Automotive Applications	• Business Equipment	
Appearance	• Clear/Transparent		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.08		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	9.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Water Absorption (24 hr, 73°F, 50RH)	0.35	%	ASTM D570
Water Absorption (Saturation, 73°F)	0.70	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	276000	psi	ASTM D638
Tensile Elongation (Break)	4.4	%	ASTM D638
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	1.1	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	189	°F	ASTM D648

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	180 to 200	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	370 to 450	°F
Middle Temperature	400 to 475	°F
Front Temperature	425 to 500	°F
Nozzle Temperature	425 to 525	°F
Processing (Melt) Temp	425 to 525	°F
Mold Temperature	120 to 170	°F
Back Pressure	25.0 to 100	psi
Screw Speed	25 to 75	rpm
Injection Notes		
Maximum Drying Time 7 hr		