AuroraTec™ 630GF

Aurora Material Solutions, LLC - *Polybutylene Terephthalate + SAN*

General Information

Product Description

AuroraTec™ 630GF is a 30% Fiberglass Reinforced, Polybutylene Terephthalate/Styrene-Acrylonitrile (PBT/SAN) Injection Molding Grade..

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Mold Release • High Heat Resistance	• Hydrolysis Resistant • Low Warpage	
Uses	• Electrical Housing	• Industrial Applications	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.46		ASTM D792
Molding Shrinkage - Flow	9.0E-3 to 0.011	in/in	ASTM D955
Water Absorption (Saturation)	0.070	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.50E+6	psi	ASTM D638
Tensile Strength (Break)	20800	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.45E+6	psi	ASTM D790
Flexural Strength	27600	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	1.0	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	330	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		Internal Method

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	220 to 250	°F
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	460 to 500	°F
Middle Temperature	480 to 520	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	480 to 520	°F
Mold Temperature	140 to 180	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 200	psi
Screw Speed	50 to 80	rpm