

AuroraGuard™ 0616R

Aurora Material Solutions, LLC - Polycarbonate

General Information

Product Description

Low Flow PC with Mold Release

Formerly known as EnPure 0616R

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Mold Release		
Features	• Good Mold Release	• Low Flow	
Uses	• Automotive Applications	• Business Equipment	
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Extrusion	• Profile Extrusion	
	• Injection Molding	• Sheet Extrusion	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8900	psi	ASTM D638
Tensile Elongation (Break)	110	%	ASTM D638
Flexural Modulus	341000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	14	ft·lb/in	
73°F	16	ft·lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	277	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	257	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-2		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 75	%
Rear Temperature	520 to 560	°F
Middle Temperature	540 to 580	°F
Front Temperature	560 to 600	°F
Nozzle Temperature	550 to 590	°F
Processing (Melt) Temp	560 to 600	°F
Mold Temperature	160 to 200	°F
Back Pressure	50.0 to 100	psi

