AuroraGuard™ ENV09-79273

Aurora Material Solutions, LLC - *Polycarbonate*

General Information

Product Description			
AuroraGuard™ ENV09-79273 is a High Viscosity, UV-Stabilized, Black Polycarbonate (PC) Injection Molding Grade.			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Heat Resistance	• Good Mold Release	
Uses	• Outdoor Applications	• Sheet	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	• Thermoforming

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)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	> 100	%	ASTM D638
Flexural Modulus	341000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	16	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	265	°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	230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	520 to 560	°F
Middle Temperature	540 to 580	°F
Front Temperature	540 to 580	°F
Nozzle Temperature	520 to 560	°F
Mold Temperature	160 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 200	psi
Screw Speed	40 to 70	rpm

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