

AuroraGuard™ F5PC

Aurora Material Solutions, LLC - Polycarbonate

General Information

Product Description

Flame Retardant, UV Stabilized PC, UL File Number E175765

Formerly known as EnPure F5PC

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant • UV Stabilizer		
Features	• Flame Retardant • UV Stabilized		
Uses	• Automotive Applications • Business Equipment	• Profiles • Thin-walled Parts	
UL File Number	• E175765		
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding • Profile Extrusion		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Molding Shrinkage - Flow (0.126 in)	6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	13	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	270	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	260	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.13 in	5VA		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220 to 250	°F
Drying Time	4.0 to 7.0	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	550 to 600	°F
Nozzle Temperature	550 to 590	°F
Processing (Melt) Temp	560 to 600	°F
Mold Temperature	160 to 210	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 70	rpm
Vent Depth	1.5E-3 to 3.0E-3	in

