

**AuroraTec™ 2006**

Aurora Material Solutions, LLC - Polycarbonate

**General Information**
**Product Description**

AuroraTec™ 2006 is an electrically conductive black (PC) injection molding grade.

**General**

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Latin America	• North America
	• Europe		
Uses	• Automotive Applications	• Business Equipment	• Thin-walled Parts
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding	• Profile Extrusion	

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.24		ASTM D792
Molding Shrinkage - Flow	8.0E-3	in/in	ASTM D955
<b>Mechanical</b>			
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	420000	psi	ASTM D790
Flexural Strength	14500	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F)	1.5	ft-lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	280	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	265	°F	ASTM D648
<b>Electrical</b>			
Surface Resistivity	5.0E+6 to 7.0E+6	ohms	Internal Method

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	220 to 250	°F
Drying Time	4.0	hr
Drying Time, Maximum	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
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 70	rpm
Vent Depth	1.5E-3 to 3.0E-3	in

