

AuroraGuard™ PC20GF

Aurora Material Solutions, LLC - Polycarbonate

General Information

Product Description

20 % Glass Reinforced PC

Formerly known as EnPure 20GF

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Uses	• Automotive Applications	• Business Equipment	• Profiles
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.126 in)	3.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	15000	psi	ASTM D638
Flexural Modulus	700000	psi	ASTM D790
Flexural Strength	18900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.0	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	290	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	285	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.13 in)	V-2		UL 94

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

