

## AuroraGuard™ PC10GF

Aurora Material Solutions, LLC - Polycarbonate

### General Information

#### Product Description

10 % Glass Reinforced PC

Formerly known as EnPure 10GF

#### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Uses	• Automotive Applications	• Business Equipment	• General Purpose
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Extrusion	• Injection Molding	

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	450000	psi	ASTM D638
Tensile Strength (Yield)	9200	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	495000	psi	ASTM D790
Flexural Strength	14500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	277	°F	ASTM D648

### 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

