

**AuroraGuard™ ENV15-78019**

Aurora Material Solutions, LLC - Polycarbonate + ABS

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

AuroraGuard™ ENV15-78019 is a black Polycarbonate/Acrylonitrile Butadiene Styrene (PC/ABS) injection molding grade.

**General**

Material Status	• Commercial: Active
Availability	• Asia Pacific • Latin America • Europe • North America
Recycled Content	• Post-Industrial (PIR)/Pre-Consumer
Features	• High Heat Resistance • Low Temperature Resistant
Uses	• Automotive Interior Parts
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	20	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	332000	psi	ISO 527-1
Tensile Stress (Yield)	7880	psi	ISO 527-2
Tensile Strain (Break)	> 50	%	ISO 527-2
Flexural Modulus	341000	psi	ISO 178
Flexural Stress	12100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-22°F	16	ft·lb/in <sup>2</sup>	
73°F	27	ft·lb/in <sup>2</sup>	
Notched Izod Impact Strength			ISO 180
-22°F	16	ft·lb/in <sup>2</sup>	
73°F	24	ft·lb/in <sup>2</sup>	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	259	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	225	°F	ISO 75-2/A
Vicat Softening Temperature	262	°F	ISO 306/B
Flammability	Nominal Value	Unit	Test Method
Burning Rate (0.125 in, Self-Extinguishing)	< 0.0	in/min	ISO 3795
Flame Rating (0.06 in)	HB		Internal Method

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	185 to 230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	437 to 455	°F
Middle Temperature	437 to 455	°F
Front Temperature	455 to 473	°F



Nozzle Temperature	491 to 509 °F
Processing (Melt) Temp	464 to 482 °F
Mold Temperature	158 to 194 °F
Injection Rate	Moderate-Fast
Back Pressure	725 to 2180 psi
Screw Speed	40 to 70 rpm

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

