

**AuroraGuard™ ENV15-70398**

Aurora Material Solutions, LLC - Polycarbonate + ABS

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

AuroraGuard ENV15-70398 is a Black Polycarbonate/Acrylonitrile Butadiene Styrene (PC/ABS). Injection Molding Grade.

Formerly branded as ENVIROLOY®.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Good Processability	• High Flow	• High Heat Resistance
Uses	• Automotive Interior Parts		
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	24	g/10 min	ASTM D1238
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7700	psi	ASTM D638
Tensile Elongation (Break)	> 110	%	ASTM D638
Flexural Modulus	334000	psi	ASTM D790
Flexural Strength	11500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-22°F	3.8	ft-lb/in	
73°F	12	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	260	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	223	°F	ASTM D648
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 215	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	480 to 520	°F
Middle Temperature	480 to 520	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	480 to 520	°F
Mold Temperature	140 to 180	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

