

AuroraGuard™ 2809

Aurora Material Solutions, LLC - Polycarbonate + ABS

General Information

Product Description

PC/ABS Alloy

Formerly known as EnValoy 2809

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Automotive Applications	• Business Equipment	
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.12		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	28	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	5.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	290000	psi	ASTM D638
Tensile Strength (Yield)	8560	psi	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	290000	psi	ASTM D790
Flexural Strength	10700	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	9.2	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	253	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	230	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180 to 220	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	450 to 500	°F
Middle Temperature	455 to 505	°F
Front Temperature	465 to 525	°F
Nozzle Temperature	475 to 525	°F
Processing (Melt) Temp	475 to 525	°F
Mold Temperature	175 to 200	°F
Back Pressure	25.0 to 100	psi
Screw Speed	25 to 75	rpm

Injection Notes

Maximum Drying Time 4.0 hrs

