

AuroraGuard™ 1218UR

Aurora Material Solutions, LLC - Polycarbonate + ABS

General Information

Product Description

Injection Grade PC/ABS Alloy with Mold Release

Formerly known as EnValoy 1218UR

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Good Mold Release		
Uses	• Appliances	• Business Equipment	• Electrical/Electronic Applications
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8350	psi	ASTM D638
Tensile Elongation (Break)	> 140	%	ASTM D638
Flexural Modulus	329000	psi	ASTM D790
Flexural Strength	12500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	12	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	265	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	230	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200 to 210	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	480 to 520	°F
Middle Temperature	490 to 520	°F
Front Temperature	490 to 530	°F
Nozzle Temperature	480 to 520	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	140 to 200	°F
Injection Notes		
Max drying time 4 hrs		

