AuroraGuard™ ENV15-NC310

Aurora Material Solutions, LLC - *Polycarbonate + ABS*

General Information

Product Description

Injection Molding Grade, Good Low Temperature Impact, RoHS Compliant
NC310 = To Be Assigned 5 Digit Number Indicating Natural, Black, or Custom Color.
The ENV15 Series Products Are Available With Mold Release and/or UV Stabilizer.

Formerly known as ENVIROLOY® ENV15-NC310

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Low Temperature Impact Resistance		
Uses	• Automotive Interior Parts	• Electronic Displays	• Recreational Vehicle Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
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)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	7600	psi	ASTM D638
Flexural Modulus	342000	psi	ASTM D790
Flexural Strength	13100	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-22°F	6.8	ft·lb/in	
73°F	11	ft·lb/in	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	250	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Burning Rate	< 3.5	in/min	FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	480 to 510	°F
Middle Temperature	500 to 520	°F
Front Temperature	510 to 530	°F
Nozzle Temperature	520 to 540	°F
Mold Temperature	150 to 190	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm