AuroraGuard™ ENV15-11044
Aurora Material Solutions, LLC - *Polycarbonate + ABS*

General Information

Product Description

AuroraGuard™ ENV15-11044 is a Natural Polycarbonate/Acrylonitrile Butadiene Styrene (PC/ABS). Injection Molding Grade.

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Latin America	
	• Europe	• North America	
Features	• High Flow	• High Heat Resistance	• Hydrolytically Stable
Uses	• Consumer Applications		
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm³	ASTM D790
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	24	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	338000	psi	ASTM D638
Tensile Stress (Yield)	7700	psi	ASTM D638
Tensile Strain (Break)	> 110	%	ASTM D638
Flexural Modulus	336000	psi	ASTM D790
Flexural Stress	12100	psi	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
--	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	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	225	°F	ISO 75-2/A

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

Additional Information	Nominal Value	Unit	Test Method
Fogging [2]	100	%	SAE J1756

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	480 to 520	°F
Middle Temperature	480 to 520	°F
Front Temperature	464 to 482	°F
Nozzle Temperature	480 to 520	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	140 to 160	°F

Injection Rate	Moderate-Fast
Back Pressure	50.0 to 200 psi
Screw Speed	40 to 70 rpm

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Clear and Dry