

AuroraGuard™ PC/ABS-80500

Aurora Material Solutions, LLC - Polycarbonate + ABS

General Information
Product Description

AuroraGuard™ PC/ABS-80500 a High Flow, White Polycarbonate/Acrylonitrile Butadiene Styrene (PCABS) Injection Molding Grade.

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Features	• High Flow
Uses	• Appliance Components
RoHS Compliance	• RoHS Compliant
Appearance	• White
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PC/ABS

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	28	g/10 min	ASTM D1238
Molding Shrinkage - Flow	4.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7900	psi	ASTM D638
Tensile Elongation (Break)	110	%	ASTM D638
Flexural Modulus	335000	psi	ASTM D790
Flexural Strength	12800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	11	ft·lb/in	ASTM D256
Gardner Impact ²	400	in·lb	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	255	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	220	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	185 to 225	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	460 to 510	°F
Middle Temperature	480 to 550	°F
Front Temperature	480 to 550	°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

