

AuroraGuard™ PC/ABS-1812

Aurora Material Solutions, LLC - Polycarbonate + ABS

General Information

Product Description

Injection Grade PC/ABS

Formerly known as EnValoy 1812

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Appliances	• Electrical/Electronic Applications	• Power/Other Tools
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 (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
Back Pressure	25.0 to 100	psi
Screw Speed	25 to 75	rpm
Vent Depth	1.5E-3 to 3.0E-3	in

Injection Notes

Maximum Drying Time 4.0 hrs

