

AuroraGuard™ PCABS15GF

Aurora Material Solutions, LLC - Polycarbonate + ABS

General Information

Product Description

15% Glass Reinforced PC/ABS

Formerly known as EnValoy 15GF

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Uses	• Automotive Applications	• Construction Applications	
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	12800	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	650000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.5	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	255	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	248	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180 to 220	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	450 to 500	°F
Middle Temperature	455 to 505	°F
Front Temperature	465 to 525	°F
Nozzle Temperature	475 to 525	°F
Processing (Melt) Temp	475 to 525	°F
Mold Temperature	175 to 200	°F
Back Pressure	25.0 to 100	psi
Screw Speed	25 to 75	rpm

Injection Notes

Maximum Drying Time 4.0 hrs

