

**AuroraTec™ 1500 EZ**

Aurora Material Solutions, LLC - Polycarbonate + ABS

**General Information**
**Product Description**

High-heat injection molding grade of Polycarbonate and Acrylonitrile Butadiene Styrene (PC/ABS) alloy. Offers high flow with hydrolytic stability, ease of processing, and mold release. Suitable for paintable applications. Contains post-industrial recycle (PIR).

Formerly branded as ENVIROLOY®

**General**

Material Status	• Commercial: Active
Availability	• Europe • Latin America • North America
Recycled Content	• Post-Industrial (PIR)/Pre-Consumer
Features	• Anti-fogging • Heat Stabilized • Hydrolytically Stable • Good Processability • High Flow • Paintable
Uses	• Automotive Interior Parts
RoHS Compliance	• RoHS Compliant
Automotive Specifications	• FORD WRS-M4D585-C2 • GM GMW15581P-ABS+PC-T6 • GM GMW15581P-ABS+PC-T3 • STELLANTIS MS.50089
Appearance	• Black • Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PC/ABS

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.14		ASTM D792
Density	1.14	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	25	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	25	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage - Flow (0.125 in)	0.40 to 0.60	%	ISO 294-4
<b>Mechanical</b>			
Tensile Strength (Yield)	7900	psi	ASTM D638
Tensile Stress (Yield)	7690	psi	ISO 527-2
Tensile Elongation (Break)	110	%	ASTM D638
Tensile Strain (Break)	60	%	ISO 527-2
Flexural Modulus	335000	psi	ASTM D790
Flexural Modulus	336000	psi	ISO 178
Flexural Strength	12800	psi	ASTM D790
Flexural Stress	12000	psi	ISO 178
<b>Impact</b>			
Charpy Notched Impact Strength			ISO 179
-22°F, 0.157 in	9.5	ft·lb/in <sup>2</sup>	
73°F, 0.157 in	22	ft·lb/in <sup>2</sup>	
Notched Izod Impact (73°F, 0.125 in)	12	ft·lb/in	ASTM D256
Gardner Impact	440	in·lb	ASTM D5420
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	248	°F	ASTM D648
Deflection Temperature Under Load (66 psi, Unannealed, 0.157 in)	250	°F	ISO 75-2/B



Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	220 °F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.157 in)	221 °F	ISO 75-2/A
Vicat Softening Temperature	255 °F	ASTM D1525 <sup>2</sup>
Vicat Softening Temperature	252 °F	ISO 306/B120
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>
Burning Rate (0.125 in, Self-Extinguishing)	0.0 in/min	ISO 3795
Flame Rating (0.06 in)	HB	UL 94
<b>Additional Information</b>	<b>Nominal Value</b>	<b>Unit</b>
Fogging <sup>3</sup>	100 %	SAE J1756

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212	°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 550	°F
Mold Temperature	140 to 180	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Rate B (120°C/h), Loading 2 (50 N)

<sup>3</sup> Clear and Dry.

