

AuroraGuard™ PC/ABS-18023

Aurora Material Solutions, LLC - *Polycarbonate + ABS*

General Information

Product Description

AuroraGuard™ PC/ABS-18023 is a Natural Polycarbonate/Acrylonitrile Butadiene Styrene (PC/ABS) for Painting Applications.

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Latin America • Europe • North America
Features	• Good Processability • High Flow • Paintable
Uses	• Automotive Applications
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.11		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7200	psi	ASTM D638
Tensile Elongation (Break)	> 80	%	ASTM D638
Flexural Modulus	300000	psi	ASTM D790
Flexural Strength	10500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-22°F	6.0	ft·lb/in	
73°F	11	ft·lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	215	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.13 in)	HB		Internal Method

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180 to 225	°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	480 to 520	°F
Nozzle Temperature	480 to 520	°F
Mold Temperature	150 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 200	psi
Screw Speed	40 to 70	rpm

