

AuroraGuard™ PC-ABS 2013R

Aurora Material Solutions, LLC - Polycarbonate + ABS

General Information
Product Description

High-flow injection molding grade of Polycarbonate / Acrylonitrile Butadiene Styrene (PC/ABS) with mold release.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Uses	• Automotive Applications	• Business Equipment	• Thin-walled Parts
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

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)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7900	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	336000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	11	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	264	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	234	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.13 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	225	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	480 to 520	°F
Middle Temperature	490 to 530	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	490 to 530	°F
Processing (Melt) Temp	475 to 525	°F
Mold Temperature	160 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 75	rpm

Injection Notes

Maximum Drying Time 4 hrs

