AuroraGuard™ GEP1013

Aurora Material Solutions, LLC - *Polycarbonate + ABS*

General Information

Product Description			
Automotive PC/ABS Alloy Formerly known as EnValoy GEP1013			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Automotive Applications	• Business Equipment	• Thin-walled Parts
Appearance	• Black		
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	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 hrs		