

**AuroraGuard™ PC/ABS-78023**

Aurora Material Solutions, LLC - Polycarbonate + ABS

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

AuroraGuard™ PC/ABS-78023 is a Black 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	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
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
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
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
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact			ASTM D256
-22°F	6.0	ft-lb/in	
73°F	11	ft-lb/in	
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	215	°F	ASTM D648
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.13 in)	HB		Internal Method

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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

