

AuroraTec™ ENV36-10959

Aurora Material Solutions, LLC - Polycarbonate + PET

General Information
Product Description

AuroraTec™ ENV36-10959 is an Impact-Modified, UV Stabilized, Natural Polycarbonate/Polyethylene Terephthalate (PC/PET) Injection Molding Grade.

Formerly branded as ENVIROLEX®

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Features	• Chemical Resistant • Good Mold Release • Low Temperature Impact Resistance • UV Resistant
Uses	• Agricultural Applications • Automotive Applications • Construction Applications • Outdoor Applications
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PC/PET

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	7.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	340000	psi	ASTM D638
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Elongation (Break)	> 150	%	ASTM D638
Flexural Modulus	347000	psi	ASTM D790
Flexural Strength	12500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	15	ft-lb/in	ASTM D256
Gardner Impact ² (73°F, 0.125 in)	430	in-lb	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	229	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		Internal Method

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200 to 230	°F
Drying Time	4.0 to 6.0	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
Mold Temperature	150 to 200	°F



Injection Rate	Moderate-Fast
Back Pressure	50.0 to 200 psi
Screw Speed	50 to 80 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² N.F.E.

