

AuroraTec™ ENV36-71751

Aurora Material Solutions, LLC - Polycarbonate + PET

General Information

Product Description

AuroraTec™ ENV36-71751 is an Impact-Modified, UV Stabilized, Black Polycarbonate/Polyethylene Terephthalate (PC/PET) Injection Molding Grade.

General

Material Status	• Commercial: Active	
Availability	• Asia Pacific	• Latin America
	• Europe	• North America
Features	• Chemical Resistant	• Low Temperature Impact Resistance
	• Good Mold Release	• UV Resistant
Uses	• Agricultural Applications	• Construction Applications
	• Automotive Applications	• Outdoor Applications
RoHS Compliance	• RoHS Compliant	
Appearance	• Black	
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) (270°C/5.0 kg)	38	g/10 min	ASTM D1238
Molding Shrinkage - Flow	6.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	331000	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	> 130	%	ASTM D638
Flexural Modulus	324000	psi	ASTM D790
Flexural Strength	12700	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)	460	in·lb	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	250	°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	160 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 200	psi
Screw Speed	50 to 80	rpm

