

AuroraTec™ ENV36-80303

Aurora Material Solutions, LLC - Polycarbonate + PET

General Information
Product Description

AuroraTec™ ENV36-80303 is a White, Polycarbonate / Polyethylene Terephthalate (PC/PET) Injection Molding Grade. This product is FDA Title 21 CFR 177.158 Polycarbonate and Title 21 CFR 176.1630 Polyethylene Phthalate Polymer Compliant, Generally Recognized Safe (GRAS) for Food Contact and Repeated Use

Formerly branded as ENVIROLEX®

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Features	• Chemical Resistant • Good Mold Release • Hydrolytically Stable • Low Temperature Impact Resistance
Uses	• Non-specific Food Applications
RoHS Compliance	• RoHS Compliant
Appearance	• White
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PC/PET

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	26	g/10 min	ASTM D1238
Molding Shrinkage - Flow	5.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	325000	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	> 200	%	ASTM D638
Flexural Modulus	304000	psi	ASTM D790
Flexural Strength	11700	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	16	ft·lb/in	ASTM D256
Gardner Impact ² (73°F, 0.125 in)	400	in·lb	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	205	°F	ASTM D648

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	480 to 520	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	480 to 520	°F
Mold Temperature	160 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 200	psi
Screw Speed	40 to 70	rpm

