

AuroraTec™ 41515IM

Aurora Material Solutions, LLC - *Polycarbonate + PET*
General Information
Product Description

Injection Grade PC/PET with UV Stabilizer and Mold Release

Formerly known as EnCounter 41515IM

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Mold Release • UV Stabilizer		
Features	• Chemical Resistant • Good Mold Release • Good Impact Resistance • UV Stabilized		
UL File Number	• E175765		
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding • Profile Extrusion		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Outdoor Suitability			UL 746C
All Colors		f2	
Black		f1	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	> 75	%	ASTM D638
Flexural Modulus	320000	psi	ASTM D790
Flexural Strength	12300	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	12	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	250	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	200	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	460 to 490	°F
Processing (Melt) Temp	470 to 500	°F
Mold Temperature	120 to 170	°F
Back Pressure	50.0 to 100	psi
Screw Speed	25 to 75	rpm

