

AuroraTec™ ENV36-80479

Aurora Material Solutions, LLC - Polycarbonate + PET

General Information
Product Description

AuroraTec™ ENV36-80479 is a High Flow, 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	• Latin America	• North America
	• Europe	• North America	
Features	• Chemical Resistant	• High Flow	• Low Temperature Impact Resistance
	• Good Mold Release	• Hydrolytically Stable	
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)	50	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	333000	psi	ASTM D638
Tensile Strength (Yield)	7800	psi	ASTM D638
Tensile Elongation (Break)	> 150	%	ASTM D638
Flexural Modulus	313000	psi	ASTM D790
Flexural Strength	11500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	14	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)	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	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	470 to 510	°F
Nozzle Temperature	470 to 510	°F
Mold Temperature	160 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 200	psi
Screw Speed	40 to 70	rpm

