

## AuroraTec™ 415TF

Aurora Material Solutions, LLC - Polycarbonate + PET

### General Information

#### Product Description

Mineral Filled PC/PET

Formerly known as EnCounter 415TF

#### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Mineral, 15% Filler by Weight		
Uses	• Appliances	• Automotive Applications	• Business Equipment
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9600	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	653000	psi	ASTM D790
Flexural Strength	16200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.2	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	258	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	232	°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

