

AuroraGuard™ 3F0

Aurora Material Solutions, LLC - Polycarbonate + PBT

General Information

Product Description

Flame Retardant PC/PBT Alloy

Formerly known as EnCounter 3F0

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Flame Retardant		
Uses	• Automotive Applications	• Industrial Applications	
Appearance	• Colors Available	• Natural Color	
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Melt Mass-Flow Rate (MFR)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	8.0E-3 to 0.011	in/in	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8560	psi	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	300000	psi	ASTM D790
Flexural Strength	10600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	7.0	ft·lb/in	ASTM D256
Gardner Impact	320	in·lb	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	205	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	25 to 75	%
Rear Temperature	460 to 480	°F
Middle Temperature	470 to 490	°F
Front Temperature	480 to 500	°F
Nozzle Temperature	480 to 500	°F
Processing (Melt) Temp	480 to 500	°F
Mold Temperature	90 to 150	°F
Back Pressure	40.0 to 90.0	psi
Screw Speed	25 to 75	rpm

