

AuroraTec™ 330GFIM1015

Aurora Material Solutions, LLC - Polycarbonate + PBT

General Information
Product Description

Impact Modified, 30% Glass Fiber Reinforced PC/PBT

Formerly known as EnCounter 330GFIM1015

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Additive	• Impact Modifier		
Features	• Impact Modified		
Uses	• Automotive Applications	• Electrical/Electronic Applications	
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical			
Tensile Strength (Yield)	13200	psi	ASTM D638
Tensile Elongation (Break)	> 3.0	%	ASTM D638
Flexural Modulus	950000	psi	ASTM D790
Flexural Strength	25000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F)	1.5	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	350	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	230	°F
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	50 to 80	%
Rear Temperature	470 to 510	°F
Middle Temperature	480 to 520	°F
Front Temperature	490 to 530	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	500 to 530	°F
Mold Temperature	150 to 190	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 80	rpm
Vent Depth	5.0E-3 to 8.0E-3	in

Injection Notes

Maximum Drying Time 8 hrs

