

## AuroraTec™ 3F0IM

Aurora Material Solutions, LLC - Polycarbonate + PBT

### General Information

#### Product Description

Impact modified Flame Retardant PC/PBT Alloy

Formerly known as EnCounter 3F0IM

#### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant • Impact Modifier		
Features	• Flame Retardant • Impact Modified		
Uses	• Electrical/Electronic Applications	• Industrial Applications	• Lighting Applications
Appearance	• Colors Available	• Natural Color	
Processing Method	• Injection Molding		

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.30		ASTM D792
Melt Mass-Flow Rate (MFR)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	8.0E-3 to 0.011	in/in	Internal Method
<b>Mechanical</b>			
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	275000	psi	ASTM D790
Flexural Strength	9750	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F)	13	ft·lb/in	ASTM D256
Gardner Impact	320	in·lb	ASTM D5420
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	215	°F	ASTM D648
<b>Flammability</b>			
Flame Rating (0.06 in)	V-0		UL 94

### Processing Information

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	220 to 240	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 75	%
Rear Temperature	460 to 480	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	480 to 500	°F
Processing (Melt) Temp	480 to 500	°F
Mold Temperature	95 to 170	°F
Back Pressure	40.0 to 90.0	psi
Screw Speed	25 to 75	rpm

