

**AuroraTec™ 308MF1013**

Aurora Material Solutions, LLC - Polycarbonate + PBT

**General Information**
**Product Description**

Mineral Filled PC/PBT

Formerly known as EnCounter 308MF1013

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Mineral, 8.0% 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	1.25		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	9.5E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8300	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	425000	psi	ASTM D790
Flexural Strength	13200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	13	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	209	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	202	°F	ASTM D648

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	230	°F
Drying Time	3.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	450 to 500	°F
Middle Temperature	460 to 510	°F
Front Temperature	470 to 520	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	490 to 520	°F
Mold Temperature	100 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	25 to 75	rpm

