

AuroraTec™ 1013U

Aurora Material Solutions, LLC - Polycarbonate + PBT

General Information

Product Description

Molding Grade PC/PBT

Formerly known as EnCounter 1013U

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Uses	• Automotive Applications	• Business Equipment	• Thin-walled Parts
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	6.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8500	psi	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	13000	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)	210	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	185	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	230 to 250	°F
Drying Time	2.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	470 to 520	°F
Middle Temperature	480 to 530	°F
Front Temperature	495 to 540	°F
Nozzle Temperature	490 to 525	°F
Processing (Melt) Temp	500 to 535	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 75	rpm

