

AuroraTec™ ENV29-1210LT-NAT

Aurora Material Solutions, LLC - Polycarbonate + PBT

General Information
Product Description

AuroraTec™ ENV29-1210LT-NAT is a Flame Retardant, Impact-Modified, UV Stabilized, Natural Polycarbonate / Polybutylene Terephthalate (PC/PBT Paintable Injection Molding Grade).

Formerly branded as ENVIRON®.

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Latin America	• North America
	• Europe		
Additive	• Flame Retardant	• Mold Release	• UV Stabilizer
Features	• Flame Retardant	• Good Mold Release	• UV Stabilized
Uses	• Electrical/Electronic Applications	• Outdoor Applications	
Agency Ratings	• EC 1907/2006 (REACH)		
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7900	psi	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus	300000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	5.0	ft-lb/in	
73°F	12	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		Internal Method

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	215 to 230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	480 to 500	°F
Middle Temperature	480 to 500	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	480 to 520	°F
Mold Temperature	150 to 190	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 200	psi
Screw Speed	50 to 80	rpm

